

Garant
Machine tap for synchronised spindles HSS-E-PM, TiAlN, M: M5

Order data

Order number	132065 M5
GTIN	4045197445964
Item class	11H

Description
Version:

Sturdy design with spiral point 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%).

Recommendation:

For **TOOLOX materials** we recommend **deviating from the DIN data** (see table) by drilling the tapping hole \varnothing **0.05** to **0.3 mm** larger.

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: 0.8 mm

Overall length L: 70 mm

Shank \varnothing D_s: 6 mm

Shank square □: 4.9 mm

Tapping hole \varnothing : 4.2 mm

Technical description

Number of clamping slots	3
Tapping hole \varnothing	4.2 mm
Thread \varnothing	5 mm

Number of cutting edges Z	3
Thread pitch	0.8 mm
Standard	Manufacturer's standard
Shank $\varnothing D_s$	6 mm
Overall length L	70 mm
Shank square \square	4.9 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Thread depth	12.5 mm
Thread type	M
Thread size	M5
Coating	TiAlN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	B
Shank	DIN 1835 B with h6
Through-coolant	no
Application for type of drilling	up to 2.5xD for through holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	red
Type of product	Tap

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	37 m/min	P
Steel < 750 N/mm ²	suitable	35 m/min	P

Steel < 900 N/mm ²	suitable	22 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
Steel < 1400 N/mm ²	suitable	7 m/min	P
TOOLOX 33	suitable	7 m/min	H
TOOLOX 44	suitable only under restricted conditions	6 m/min	H
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		