

Garant
Machine tap HSS-E-PM, TiCN, M: M4

Order data

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|--------------|---------------|
| Order number | 132055 M4 |
| GTIN | 4045197648686 |
| Item class | 11H |

Description
Version:
Sturdy version.
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 0.3 mm** larger. For use only with a length compensation chuck – even on machines with synchronised spindle drives.

Thread type: M

Tool material: HSS E PM

Standard: DIN 371

Tolerance class: ISO 2X 6HX

Thread pitch: 0.7 mm

Overall length L: 63 mm

 Shank \varnothing D_s: 4.5 mm

Shank square □: 3.4 mm

 Tapping hole \varnothing : 3.3 mm

Technical description

| | |
|----------------------------|---------|
| Thread \varnothing | 4 mm |
| Number of clamping slots | 2 |
| Number of cutting edges Z | 2 |
| Thread pitch | 0.7 mm |
| Tapping hole \varnothing | 3.3 mm |
| Standard | DIN 371 |

| | |
|----------------------------------|-----------------------------------|
| Shank $\varnothing D_s$ | 4.5 mm |
| Overall length L | 63 mm |
| Shank square \square | 3.4 mm |
| Tolerance class | ISO 2X 6HX |
| Tool material | HSS E PM |
| Thread depth | 6 mm |
| Thread type | M |
| Thread size | M4 |
| Coating | TiCN |
| Flank angle | 60° |
| Thread standard | DIN 13 |
| Taper lead form | C |
| Shank | Plain shank with h9 |
| Through-coolant | no |
| Application for type of drilling | up to 1.5×D for through holes |
| Application for type of drilling | up to 1.5×D for blind 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_c | ISO code |
|--------------------------------|-------------|----------|----------|
| Steel < 1100 N/mm ² | suitable | 12 m/min | P |
| Steel < 1400 N/mm ² | suitable | 7 m/min | P |
| Steel < 55 HRC | suitable | 2 m/min | H |
| TOOLOX 33 | suitable | 4 m/min | H |
| TOOLOX 44 | suitable | 3 m/min | H |

| | | | |
|---|--|----------|---|
| HARDOX 500 < 1600 N/ mm ² | suitable | 2 m/min | H |
| Graphite, GRP, CRP | suitable only under restricted conditions | 15 m/min | N |
| Oil | suitable | | |