

## Garant

### Machine tap for synchronised spindles HSS-E-PM, TiAlN, M: M10



#### Order data

Order number	132065 M10
GTIN	4045197445995
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: 1.5 mm

Overall length L: 100 mm

Shank  $\varnothing$  D<sub>s</sub>: 10 mm

Shank square □: 8 mm

Tapping hole  $\varnothing$ : 8.5 mm

#### Technical description

Tapping hole $\varnothing$	8.5 mm
Thread pitch	1.5 mm
Number of cutting edges Z	3

Number of clamping slots	3
Thread Ø	10 mm
Standard	Manufacturer's standard
Shank Ø D <sub>s</sub>	10 mm
Overall length L	100 mm
Shank 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	B
Shank	DIN 1835 B with h6
Through-coolant	no
Application for type of drilling	up to 2.5×D 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 <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	37 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	35 m/min	P

Steel < 900 N/mm <sup>2</sup>	suitable	22 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	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		