

**Garant****Machine tap, uncoated, M: M3,5****Order data**

|              |               |
|--------------|---------------|
| Order number | 131950 M3,5   |
| GTIN         | 4045197070883 |
| Item class   | 11H           |

**Description****Version:****Sturdy version.****Recommendation:**

For **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.

Thread type: M

Tool material: HSS E

Standard: DIN 371

Tolerance class: ISO 2X 6HX

Thread pitch: 0.6 mm

Overall length L: 56 mm

Shank  $\varnothing$  D<sub>s</sub>: 4 mm

Shank square □: 3 mm

Tapping hole  $\varnothing$ : 2.9 mm**Technical description**

|                                    |         |
|------------------------------------|---------|
| Number of cutting edges Z          | 3       |
| Number of clamping slots           | 3       |
| Thread pitch                       | 0.6 mm  |
| Thread $\varnothing$               | 3.5 mm  |
| Tapping hole $\varnothing$         | 2.9 mm  |
| Standard                           | DIN 371 |
| Shank $\varnothing$ D <sub>s</sub> | 4 mm    |

|                                  |                                   |
|----------------------------------|-----------------------------------|
| Overall length L                 | 56 mm                             |
| Shank square □                   | 3 mm                              |
| Tolerance class                  | ISO 2X 6HX                        |
| Tool material                    | HSS E                             |
| Thread depth                     | 5.25 mm                           |
| Thread type                      | M                                 |
| Thread size                      | M3.5                              |
| Coating                          | uncoated                          |
| 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 <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 750 N/mm <sup>2</sup>  | suitable only under restricted conditions | 15 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 15 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 6 m/min        | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 3 m/min        | P        |
| TOOLOX 33                      | suitable                                  | 4 m/min        | H        |

|                                     |   |         |   |
|-------------------------------------|---|---------|---|
| TOOLOX 44                           | suitable only under restricted conditions | 3 m/min | H |
| HARDOX 500 < 1600 N/mm <sup>2</sup> | suitable only under restricted conditions | 3 m/min | H |
| Oil                                 | suitable                                  |         |   |
| wet maximum                         | suitable only under restricted conditions |         |   |