

**Garant**
**Machine tap HSS-E, TiCN, M: M14**

**Order data**

Order number	131930 M14
GTIN	4045197070821
Item class	11H

**Description**
**Version:**
**With spiral point.**

For use with **emulsion** (fat content minimum 8%).

**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 376

Tolerance class: ISO 2X 6HX

Thread pitch: 2 mm

Overall length L: 110 mm

Shank  $\varnothing$  D<sub>s</sub>: 11 mm

Shank square □: 9 mm

Tapping hole  $\varnothing$ : 12 mm

**Technical description**

Number of cutting edges Z	3
Tapping hole $\varnothing$	12 mm
Number of clamping slots	3
Thread $\varnothing$	14 mm
Thread pitch	2 mm
Standard	DIN 376

Shank $\varnothing D_s$	11 mm
Overall length L	110 mm
Shank square $\square$	9 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E
Thread depth	42 mm
Thread type	M
Thread size	M14
Coating	TiCN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for through 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 < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	20 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	19 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	19 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	9 m/min	P
TOOLOX 33	suitable	4 m/min	H
Oil	suitable		

wet maximum

suitable