

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

Order data

Order number	132280 M10
GTIN	4045197446145
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-S coating** for optimum tool life. For use with **emulsion** (fat content minimum 8%).

Note:

For use on synchronised spindles, the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures maximum 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 $\varnothing D_s$: 10 mm

Shank square \square : 8 mm

Tapping hole \varnothing : 8.5 mm

Technical description

Number of cutting edges Z	3
Number of clamping slots	3
Thread \varnothing	10 mm
Thread pitch	1.5 mm
Tapping hole \varnothing	8.5 mm

Standard	Manufacturer's standard
Shank $\varnothing D_s$	10 mm
Overall length L	100 mm
Shank square \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 2.5xD for through holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	blue
Type of product	Tap

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	40 m/min	N
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

INOX < 900 N/mm ²	suitable	12 m/min	M
INOX > 900 N/mm ²	suitable	10 m/min	M
CuZn	suitable only under restricted conditions	35 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		