

**Garant**
**Machine tap Form D, vaporised, M: M6**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 132155 M6     |
| GTIN         | 4045197446053 |
| Item class   | 11H           |

**Description**
**Version:**

Particularly sturdy design.

**Taper lead form D with 15° left-hand spiral.**

**Callout:**

Oil groove

Guide thread

Lead-in

Spiral point

**Advantage:**

Special geometry enables **higher cutting speeds and long tool life in stainless steel.**

Thread type: M

Tool material: HSS E

Standard: DIN 371

Tolerance class: ISO 2X 6HX

Thread pitch: 1 mm

Overall length L: 80 mm

Shank  $\varnothing D_s$ : 6 mm

Shank square  $\square$ : 4.9 mm

Tapping hole  $\varnothing$ : 5 mm

**Technical description**

|                            |      |
|----------------------------|------|
| Tapping hole $\varnothing$ | 5 mm |
| Number of clamping slots   | 3    |
| Thread pitch               | 1 mm |
| Number of cutting edges Z  | 3    |

|                                  |                                   |
|----------------------------------|-----------------------------------|
| Thread Ø                         | 6 mm                              |
| Standard                         | DIN 371                           |
| Shank Ø D <sub>s</sub>           | 6 mm                              |
| Overall length L                 | 80 mm                             |
| Shank square □                   | 4.9 mm                            |
| Tolerance class                  | ISO 2X 6HX                        |
| Tool material                    | HSS E                             |
| Thread depth                     | 18 mm                             |
| Thread type                      | M                                 |
| Thread size                      | M6                                |
| Coating                          | vaporised                         |
| Flank angle                      | 60°                               |
| Thread standard                  | DIN 13                            |
| Taper lead form                  | D                                 |
| Helix angle                      | 15°                               |
| 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                      | blue                              |
| Type of product                  | Tap                               |

## User data

|                               | Suitability                               | V <sub>c</sub> | ISO code |
|-------------------------------|---|----------------|----------|
| Aluminium (short chipping)    | suitable only under restricted conditions | 13 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup> | suitable                                  | 15 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable                                  | 15 m/min       | P        |

|                               |   |          |   |
|-------------------------------|---|----------|---|
| Steel < 900 N/mm <sup>2</sup> | suitable only under restricted conditions | 15 m/min | P |
| INOX < 900 N/mm <sup>2</sup>  | suitable                                  | 13 m/min | M |
| CuZn                          | suitable only under restricted conditions | 13 m/min | N |
| Oil                           | suitable                                  |          |   |
| wet maximum                   | suitable only under restricted conditions |          |   |