

**Garant**
**Fluteless machine tap without oil grooves HSS-E-PM 6HX, TiN, M: M1**

**Order data**

Order number	139125 M1
GTIN	4045197649683
Item class	11H

**Description**
**Version:**

Size M1–M1.4 – **tolerance class:** ISO 1X / 4HX

**DIN 2174** ( $\approx$  **DIN 371**  $\leq$  M10;  $\approx$  **DIN 376**  $\geq$  M12).

The **innovative polygon form** permits a wide application spectrum. The **multi-function layer structure** achieves **maximum service life** even in **high-tensile materials**.

Tolerance class: ISO 1X 4HX

Thread pitch: 0.25 mm

Overall length L: 40 mm

Shank  $\varnothing D_s$ : 2.5 mm

Shank square  $\square$ : 2.1 mm

Tapping hole  $\varnothing$  guide value: 0.9 mm

**Technical description**

Number of cutting edges Z	1
Thread $\varnothing$	1 mm
Thread pitch	0.25 mm
Number of clamping slots	1
Shank $\varnothing D_s$	2.5 mm
Shank square $\square$	2.1 mm
Overall length L	40 mm
Tapping hole $\varnothing$ guide value	0.9 mm
Tolerance class	ISO 1X 4HX

Thread depth	1.5 mm
Thread size	M1
Coating	TiN
Thread type	M
Flank angle	60°
Tool material	HSS E PM
Standard	DIN 2174
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
Colour ring	green
Type of product	Fluteless tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable only under restricted conditions	42 m/min	N
Aluminium (short chipping)	suitable	42 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	37 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	32 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	27 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	22 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	17 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	12 m/min	M

CuZn	suitable only under restricted conditions	22 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		