Garant

GARANT Master Form Steel fluteless machine tap with oil grooves Left-hand thread HSS-E-PM Form C 6HX, TiAlN, M-LH: M10

Order data

Order number	139255 M10
GTIN	4062406383800
Item class	11l

Description

Version:
The latest generation of **high-performance fluteless taps**, specially developed for **use in steel materials.**
· **Optimised polygon geometry for a lower torque.**
· **Multi-layer HIPIMS coating for high wear resistance.**
· **HSS-E-PM substrate for exceptional process reliability.**
DIN 2174 (≈ DIN 371 ≤ M10; ≈ **DIN 376** ≥ M12**).**
Tolerance class: ISO 2X 6HX
Thread pitch: 1.5 mm
Overall length L: 100 mm
Shank ⌀ D_s: 10 mm
Shank square ☐: 8 mm
Tapping hole ⌀ guide value: 9.35 mm

Technical description

Tolerance class	ISO 2X 6HX
Thread size	M10 LH
Thread ⌀	10 mm
Thread pitch	1.5 mm
Tapping hole ⌀ guide value	9.35 mm
Shank ⌀ D_s	10 mm
Overall length L	100 mm

Shank square ☐	8 mm
Number of cutting edges Z	6
Series	GARANT Master
Number of clamping slots	6
Thread depth	30 mm
Coating	TiAlN
Thread type	M-LH
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 3×D for blind holes
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Colour ring	without
Type of product	Fluteless tap

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable	38 m/min	N
Steel < 500 N/mm²	suitable	37 m/min	P
Steel < 750 N/mm²	suitable	35 m/min	P
Steel < 900 N/mm²	suitable	27 m/min	P
Steel < 1100 N/mm²	suitable	18 m/min	P
Steel < 1400 N/mm²	suitable	12 m/min	P

INOX < 900 N/mm²	suitable	12 m/min	M
INOX > 900 N/mm²	suitable	7 m/min	M
CuZn	suitable only under restricted conditions	22 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		