

Garant

Fluteless machine tap with oil grooves extra long HSS-E-PM Form C 6HX, TiAlN, M: M4



Order data

Order number	139208 M4
GTIN	4062406383688
Item class	111

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.**

Tolerance class: ISO 2X/6HX.

With extra long shank.

Advantage:

Ideal for thread forming where access is difficult.

Tolerance class: ISO 2X 6HX

Thread pitch: 0.7 mm

Overall length L: 126 mm

Shank \varnothing D_s: 4.5 mm

Shank square □: 3.4 mm

Tapping hole \varnothing guide value: 3.7 mm

Technical description

Overall length L	126 mm
Number of clamping slots	5
Thread pitch	0.7 mm
Thread depth	12 mm
Thread \varnothing	4 mm

Number of cutting edges Z	5
Tolerance class	ISO 2X 6HX
Shank $\varnothing D_s$	4.5 mm
Shank square \square	3.4 mm
Series	GARANT Master
Thread size	M4
Tapping hole \varnothing guide value	3.7 mm
Coating	TiAlN
Thread type	M
Flank angle	60°
Tool material	HSS E PM
Standard	Manufacturer's standard
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3xD for blind holes
Application for type of drilling	up to 3xD 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	34 m/min	N
Steel < 500 N/mm ²	suitable	33 m/min	P
Steel < 750 N/mm ²	suitable	32 m/min	P
Steel < 900 N/mm ²	suitable	24 m/min	P

Steel < 1100 N/mm ²	suitable	16 m/min	P
Steel < 1400 N/mm ²	suitable	10 m/min	P
INOX < 900 N/mm ²	suitable	10 m/min	M
CuZn	suitable	20 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		