

Garant

GARANT Master Form Steel fluteless machine tap with oil grooves HSS-E-PM IC, TiAlN, MF: 10X1



Order data

Order number	139290 10X1
GTIN	4062406383954
Item class	111

Description

Version:

GARANT Master Form Steel:

The latest generation of **high-performance fluteless taps** are specially developed for **use in steels**.

- **Optimised polygon geometry for a reduced torque.**
- **Multi-layer HIPIMS coating for high wear resistance.**
- **HSS-E-PM substrate for top process reliability.**

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

With internal coolant feed laterally from the grooves. Permits the longest possible tool life when machining through holes and blind holes.

Tolerance class: ISO 2X 6HX

Thread pitch: 1 mm

Overall length L: 90 mm

Shank $\varnothing D_s$: 10 mm

Shank square \square : 8 mm

Tapping hole \varnothing guide value: 9.55 mm

Technical description

Shank $\varnothing D_s$	10 mm
Series	GARANT Master
Number of cutting edges Z	6
Thread depth	30 mm

Tapping hole Ø guide value	9.55 mm
Thread size	M10×1
Thread pitch	1 mm
Thread Ø	10 mm
Number of clamping slots	6
Shank square □	8 mm
Tolerance class	ISO 2X 6HX
Overall length L	90 mm
Coating	TiAlN
Thread type	MF
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	yes
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 only under restricted conditions	42 m/min	N
Steel < 500 N/mm ²	suitable	40 m/min	P
Steel < 750 N/mm ²	suitable	38 m/min	P

Steel < 900 N/mm ²	suitable	29 m/min	P
Steel < 1100 N/mm ²	suitable	20 m/min	P
Steel < 1400 N/mm ²	suitable	15 m/min	P
INOX < 900 N/mm ²	suitable	15 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	8 m/min	M
CuZn	suitable only under restricted conditions	25 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		