ᵢᵦ Hoffmann Group

Garant

Fluteless machine tap with oil grooves HSS-E-PM IC / Form C 6HX, TiAlN, M: M6

Order data

Order number	139202 M6
GTIN	4062406383473
Item class	11I

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). With oil grooves; optimum lubrication effect even in deeper threads.
Tolerance class: ISO 2X/6HX.
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: 80 mm
Shank Ø D_s: 6 mm
Shank square □: 4.9 mm
Tapping hole Ø guide value: 5.55 mm

Technical description

Tapping hole Ø guide value	5.55 mm
Shank Ø D_s	6 mm
Tolerance class	ISO 2X 6HX
Thread depth	18 mm

Number of cutting edges Z	5
Thread size	M6
Thread pitch	1 mm
Series	GARANT Master
Number of clamping slots	5
Thread Ø	6 mm
Overall length L	80 mm
Shank square □	4.9 mm
Coating	TiAlN
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	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	42 m/min	N
Steel < 500 N/mm²	suitable	40 m/min	P
Steel < 750 N/mm²	suitable	38 m/min	P

Steel < 900 N/mm²	suitable	29 m/min	P
Steel < 1100 N/mm²	suitable	20 m/min	P
Steel < 1400 N/mm²	suitable	15 m/min	P
INOX < 900 N/mm²	suitable	15 m/min	M
INOX > 900 N/mm²	suitable	8 m/min	M
CuZn	suitable	25 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		