

Garant

GARANT Master Form Steel fluteless machine tap with oil grooves HSS-E-PM Form C 6HX, TiAlN, M: M6



Order data

| | |
|--------------|---------------|
| Order number | 139194 M6 |
| GTIN | 4062406381189 |
| 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.**

DIN 2174 (≈ DIN 371 ≤ M10; ≈ DIN 376 ≥ M12).

Tolerance class: ISO 2X/6HX.

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

| | |
|---------------------------|---------------|
| Thread depth | 18 mm |
| Shank Ø D _s | 6 mm |
| Overall length L | 80 mm |
| Thread Ø | 6 mm |
| Series | GARANT Master |
| Number of cutting edges Z | 5 |

| | |
|---------------------------------------|-----------------------------|
| Thread pitch | 1 mm |
| Shank square <input type="checkbox"/> | 4.9 mm |
| Thread size | M6 |
| Tapping hole Ø guide value | 5.55 mm |
| Tolerance class | ISO 2X 6HX |
| Number of clamping slots | 5 |
| 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 | 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/mm ² | suitable | 37 m/min | P |
| Steel < 750 N/mm ² | suitable | 35 m/min | P |
| Steel < 900 N/mm ² | suitable | 27 m/min | P |
| Steel < 1100 N/mm ² | suitable | 18 m/min | P |

| | | | |
|--------------------------------|----------|----------|---|
| Steel < 1400 N/mm ² | suitable | 12 m/min | P |
| INOX < 900 N/mm ² | suitable | 12 m/min | M |
| INOX > 900 N/mm ² | suitable | 7 m/min | M |
| CuZn | suitable | 22 m/min | N |
| Oil | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |