

## Garant

### GARANT Master Form Steel fluteless machine tap with oil grooves HSS-E-PM, TiAlN, MF: 6X0,75



#### Order data

|              |               |
|--------------|---------------|
| Order number | 139280 6X0,75 |
| GTIN         | 4062406383848 |
| 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.**

<strong>DIN 2174</strong> (≈ <strong>DIN 371</strong> ≤ M10; <strong>DIN 376</strong> ≥ M12).

Tolerance class: ISO 2X 6HX

Thread pitch: 0.75 mm

Overall length L: 80 mm

Shank Ø D<sub>s</sub>: 6 mm

Shank square □: 4.9 mm

Tapping hole Ø guide value: 5.65 mm

#### Technical description

|                           |         |
|---------------------------|---------|
| Shank Ø D <sub>s</sub>    | 6 mm    |
| Thread depth              | 18 mm   |
| Number of cutting edges Z | 5       |
| Thread pitch              | 0.75 mm |
| Overall length L          | 80 mm   |

|                                  |                             |
|----------------------------------|-----------------------------|
| Tolerance class                  | ISO 2X 6HX                  |
| Thread Ø                         | 6 mm                        |
| Series                           | GARANT Master               |
| Tapping hole Ø guide value       | 5.65 mm                     |
| Thread size                      | M6×0.75                     |
| Shank square □                   | 4.9 mm                      |
| Number of clamping slots         | 5                           |
| 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                  | 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 <sub>c</sub> | ISO code |
|-------------------------------|---|----------------|----------|
| Aluminium (short chipping)    | suitable only under restricted conditions | 38 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup> | suitable                                  | 37 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable                                  | 35 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup> | suitable                                  | 27 m/min       | P        |

|                                |   |          |   |
|--------------------------------|---|----------|---|
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 18 m/min | P |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 12 m/min | P |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 12 m/min | M |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 7 m/min  | M |
| CuZn                           | suitable only under restricted conditions | 22 m/min | N |
| Oil                            | suitable                                  |          |   |
| wet maximum                    | suitable                                  |          |   |
| wet minimum                    | suitable                                  |          |   |