Garant

GARANT Master Form Steel fluteless machine tap with oil grooves HSS-E-PM IC, TiAlN, MF: 14X1,5

Order data

Order number	139290 14X1,5
GTIN	4062406383985
Item class	11l

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 (≈ DIN 371 ≤ M10; DIN 376≥ 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: 1.5 mm
Overall length L: 100 mm
Shank ⌀ D_s: 11 mm
Shank square ☐: 9 mm
Tapping hole ⌀ guide value: 13.3 mm

Technical description

Overall length L	100 mm
Thread pitch	1.5 mm
Number of clamping slots	8
Thread ⌀	14 mm

Thread depth	42 mm
Tolerance class	ISO 2X 6HX
Number of cutting edges Z	8
Thread size	M14×1.5
Shank square ☐	9 mm
Tapping hole ∅ guide value	13.3 mm
Shank ∅ D_s	11 mm
Series	GARANT Master
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/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 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		