

## Garant

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



#### Order data

Order number	139205 M6
GTIN	4062406383565
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** ( $\approx$  DIN 371  $\leq$  M10;  $\approx$  DIN 376  $\geq$  M12).

**Tolerance class: ISO 3X/6GX.**

##### Application:

For components which are **galvanised**, or shrink slightly when hardened.

Tolerance class: ISO 3X 6GX

Thread pitch: 1 mm

Overall length L: 80 mm

Shank  $\varnothing$  D<sub>s</sub>: 6 mm

Shank square  $\square$ : 4.9 mm

Tapping hole  $\varnothing$  guide value: 5.55 mm

#### Technical description

Number of clamping slots	5
Thread size	M6
Thread pitch	1 mm
Overall length L	80 mm
Thread depth	18 mm

Shank $\varnothing D_s$	6 mm
Thread $\varnothing$	6 mm
Shank square $\square$	4.9 mm
Tapping hole $\varnothing$ guide value	5.55 mm
Series	GARANT Master
Number of cutting edges Z	5
Tolerance class	ISO 3X 6GX
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 <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	7 m/min	M
CuZn	suitable	22 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		