

## Garant

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



#### Order data

Order number	139255 M6
GTIN	4062406383787
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

Thread pitch: 1 mm

Overall length L: 80 mm

Shank Ø D<sub>s</sub>: 6 mm

Shank square □: 4.9 mm

Tapping hole Ø guide value: 5.55 mm

#### Technical description

Thread depth	18 mm
Tapping hole Ø guide value	5.55 mm
Shank square □	4.9 mm
Series	GARANT Master
Overall length L	80 mm
Number of cutting edges Z	5
Number of clamping slots	5

Thread Ø	6 mm
Thread size	M6 LH
Tolerance class	ISO 2X 6HX
Shank Ø D <sub>s</sub>	6 mm
Thread pitch	1 mm
Coating	TiAlN
Thread type	M-LH
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	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 only under restricted conditions	22 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		