

Garant**Machine tap for synchronised spindles HSS-E-PM Form C, TiAlN, M: M4****Order data**

| | |
|--------------|---------------|
| Order number | 132555 M4 |
| GTIN | 4045197585257 |
| Item class | 11H |

Description**Version:**

Sturdy design with shank to DIN 1835-B. Special geometry for use on machines with **synchronised spindle drives**. The tap is controlled by the synchronising spindle of the machine. **Special TiAlN coating for optimum tool life.** For use with **emulsion** (fat content minimum 8 %).

Also outstandingly suitable for **bainite cast iron (ADI)**.

Note:

For use on synchronised spindles, the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures maximum process reliability.

Technical description

| | |
|---------------------------|-------------------------|
| Number of clamping slots | 3 |
| Thread pitch | 0.7 mm |
| Tapping hole Ø | 3.3 mm |
| Number of cutting edges Z | 3 |
| Thread Ø | 4 mm |
| Standard | Manufacturer's standard |
| Shank Ø D _s | 6 mm |
| Overall length L | 70 mm |
| Shank square □ | 4.9 mm |
| Tolerance class | ISO 2X 6HX |

Data sheet

| | |
|----------------------------------|---------------------------------------|
| Tool material | HSS E PM |
| Thread depth | 10 mm |
| Thread type | M |
| Thread size | M4 |
| Coating | TiAlN |
| Flank angle | 60 degrees |
| Thread standard | DIN 13 |
| Taper lead form | C |
| Shank | DIN 1835 B with h6 |
| Through-coolant | no |
| Application for type of drilling | up to 2×D for blind holes |
| Application for type of drilling | up to 2.5×D for through holes |
| Cutting direction | right-hand |
| Shank tolerance | h6 |
| Type of threading tool | Machine tap for synchronous machining |
| Colour ring | white |
| Type of product | Tap |

User data

| | Suitability | V _c | ISO code |
|---------------------------------|---|----------------|----------|
| GJS, ADI > 800N/mm ² | suitable | 20 m/min | K |
| wet maximum | suitable | | |
| wet minimum | suitable only under restricted conditions | | |
| Air | suitable only under restricted conditions | | |