

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

**Order data**

Order number	132560 M4
GTIN	4045197585318
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.

Thread type: M

Tool material: HSS E PM

Standard: Manufacturer's standard

Tolerance class: ISO 2X 6HX

Thread pitch: 0.7 mm

Overall length L: 70 mm

Shank  $\varnothing D_s$ : 6 mm

Shank square  $\square$ : 4.9 mm

Tapping hole  $\varnothing$ : 3.3 mm

**Technical description**

Number of clamping slots	3
Tapping hole $\varnothing$	3.3 mm
Thread pitch	0.7 mm
Thread $\varnothing$	4 mm

Number of cutting edges Z	3
Standard	Manufacturer's standard
Shank $\varnothing D_s$	6 mm
Overall length L	70 mm
Shank square $\square$	4.9 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Thread depth	10 mm
Thread type	M
Thread size	M4
Coating	TiAlN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	E
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 <sup>2</sup>	suitable	20 m/min	K
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
Air	suitable only under restricted conditions