

**Garant**
**Machine tap HSS-E, TiCN, M: M4**

**Order data**

Order number	132450 M4
GTIN	4045197071644
Item class	11H

**Description**
**Version:**

**Strong spiral point. Guide section with oil grooves, but without chip flutes.**

Particularly suitable for **difficult to machine steels up to 850 N/mm<sup>2</sup>**.

For use with **emulsion** (fat content minimum 8%).

**Advantage:**

**Particularly strong, optimum self-guidance and no recutting** when reversed.

Thread type: M

Tool material: HSS E

Standard: DIN 371

Tolerance class: ISO 2X 6HX

Thread pitch: 0.7 mm

Overall length L: 63 mm

Shank  $\varnothing D_s$ : 4.5 mm

Shank square  $\square$ : 3.4 mm

Tapping hole  $\varnothing$ : 3.3 mm

**Technical description**

Tapping hole $\varnothing$	3.3 mm
Thread pitch	0.7 mm
Number of clamping slots	3
Number of cutting edges Z	3
Thread $\varnothing$	4 mm
Standard	DIN 371

Shank $\varnothing D_s$	4.5 mm
Overall length L	63 mm
Shank square $\square$	3.4 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E
Thread depth	8 mm
Thread type	M
Thread size	M4
Coating	TiCN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	pink
Type of product	Tap

## User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	16 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	19 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	19 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	8 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	6 m/min	M

Ti > 850 N/mm <sup>2</sup>	suitable	4 m/min	S
Inconel	suitable	2 m/min	S
CuZn	suitable only under restricted conditions	16 m/min	N
Oil	suitable		
wet maximum	suitable		