

**Garant**
**Fluteless machine tap with oil grooves HSS-E-PM Form E 6HX, TiAlN, M: M3,5**

**Order data**

Order number	139198 M3,5
GTIN	4062406383381
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 2X/6HX.**

**Form E** (lead-in 1.5 – 2 turns) **for deep threads with short run-out.** The thread is tapped almost to the bottom of the hole.

Tolerance class: ISO 2X 6HX

Thread pitch: 0.6 mm

Overall length L: 56 mm

Shank  $\varnothing$  D<sub>s</sub>: 4 mm

Shank square □: 3 mm

Tapping hole  $\varnothing$  guide value: 3.25 mm

**Technical description**

Thread depth	10.5 mm
Number of cutting edges Z	4
Shank $\varnothing$ D <sub>s</sub>	4 mm
Series	GARANT Master
Overall length L	56 mm

Number of clamping slots	4
Thread size	M3.5
Shank square □	3 mm
Tolerance class	ISO 2X 6HX
Thread Ø	2.9 mm
Thread pitch	0.6 mm
Tapping hole Ø guide value	3.25 mm
Coating	TiAlN
Thread type	M
Flank angle	60°
Tool material	HSS E PM
Standard	DIN 2174
Thread standard	DIN 13
Taper lead form	E
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	22 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		