

## Garant

### GARANT Master Tap machine tap HSS-E-PM extra long Form C 6HX DIN 376, AlTiX, M: M4



#### Order data

Order number	136168 M4
GTIN	4062406710989
Item class	111

#### Description

##### Version:

**Universal taps**, designed for use in a wide spectrum of materials with high process reliability.

- **HSS-E-PM tool material for a high degree of wear resistance.**
- **Reduced coefficient of friction due to the new high-performance coating.**
- **Special geometry for optimum swarf evacuation.**

With extra long shank.

**All sizes** with shank to DIN 376 (= **shank Ø tapered**). Therefore suitable for greater operating depths.

##### Advantage:

Designed for tapping threads where access is difficult.

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: 125 mm

Shank Ø D<sub>s</sub>: 2.8 mm

Shank square □: 2.1 mm

Tapping hole Ø: 3.3 mm

#### Technical description

Thread Ø	4 mm
Thread type	M
Shank square □	2.1 mm

Thread depth	10 mm
Thread pitch	0.7 mm
Tapping hole Ø	3.3 mm
Standard	Manufacturer's standard
Number of cutting edges Z	3
Thread size	M4
Tool material	HSS E PM
Overall length L	125 mm
Number of clamping slots	3
Tolerance class	ISO 2X 6HX
Shank Ø D <sub>s</sub>	2.8 mm
Coating	AlTiX
Flank angle	60 °
Thread standard	DIN 13
Helix angle	40 °
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2.5×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Series	Master Tap
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	24 m/min	N
Aluminium (short chipping)	suitable	28 m/min	N

Alu > 10% Si	suitable	16 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	24 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	24 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	10 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	6 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
GG(G)	suitable	16 m/min	K
CuZn	suitable	16 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		