

Garant
GARANT Master Tap SteelHT machine tap HSS-E-PM Form C 6HX, TiAlN, M: M30

Order data

Order number	135371 M30
GTIN	4067263829676
Item class	111

Description
Version:

High-performance tap, specially developed for use in **steels with high tensile strength** and for **difficult-to-machine materials**. Sturdy design with **optimised guide thread to avoid chips jamming**.

- **HSS-E-PM tool material – for very high cutting edge stability.**
- **Optimised honed cutting edges.**
- **TiAlN coating – for maximum wear protection.**

Recommendation:

For **TOOLOX** and **HARDOX** materials we recommend deviating from the DIN data (see table) by selecting a larger tapping hole \varnothing .

Note:

For **TOOLOX** and **HARDOX** materials: do not exceed the maximum thread depth $2 \times D$!

Technical description

Tapping hole \varnothing	26.5 mm
Overall length L	180 mm
Standard	DIN 376
Thread type	M
Thread \varnothing	30 mm
Shank square \square	18 mm
Thread pitch	3.5 mm

Number of clamping slots	4
Thread size	M30
Number of cutting edges Z	4
Tool material	HSS E PM
Shank $\varnothing D_s$	22 mm
Tolerance class	ISO 2X 6HX
Thread depth	75 mm
Coating	TiAlN
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 degrees
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	red
Series	Master Tap
Type of product	Tap

User data

	Suitability	V_c	ISO code
Steel < 750 N/mm ²	suitable only under restricted conditions	30 m/min	P
Steel < 900 N/mm ²	suitable	20 m/min	P
Steel < 1100 N/mm ²	suitable	15 m/min	P
Steel < 1400 N/mm ²	suitable	12 m/min	P

Steel < 50 HRC	suitable only under restricted conditions		
TOOLOX 33	suitable	15 m/min	H
TOOLOX 44	suitable		
INOX > 900 N/mm ²	suitable		
Ti > 850 N/mm ²	suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		