Garant

Machine tap for synchronised spindles HSS-E-PM Form B 6HX, TiAlN, M: M10

Order data

Order number	132741 M10
GTIN	4045197867421
Item class	11H

Description

Version:
Sturdy version with lead-in taper and **shank to DIN 1835-B.** Special geometry for **general-purpose use** on machines with **synchronised spindle drive.** The tap is controlled by the synchronising spindle of the machine.
Special TiAlN coating for optimum tool life.
Can be used with **emulsion** (fat content minimum 8%).
Note:
For use on synchronised spindles, the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures very high process reliability.
Thread type: M
Tool material: HSS E PM
Standard: Manufacturer's standard
Tolerance class: ISO 2X 6HX
Thread pitch: 1.5 mm
Overall length L: 100 mm
Shank ⌀ D_s: 10 mm
Shank square ☐: 8 mm
Tapping hole ⌀: 8.5 mm

Technical description

Shank ⌀ D_s	10 mm
Tapping hole ⌀	8.5 mm
Thread ⌀	10 mm
Number of cutting edges Z	3
Number of clamping slots	3

Thread pitch	1.5 mm
Tool material	HSS E PM
Standard	Manufacturer's standard
Tolerance class	ISO 2X 6HX
Overall length L	100 mm
Shank square ☐	8 mm
Thread depth	30 mm
Thread type	M
Thread size	M10
Coating	TiAlN
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	B
Shank	DIN 1835 B to h6
Through-coolant	no
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Maskinsnittapper til synkron bearbejdning
Colour ring	green
Type of product	Tap

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	40 m/min	N
Aluminium (short chipping)	suitable	40 m/min	N
Steel < 500 N/mm²	suitable	37 m/min	P

Steel < 750 N/mm²	suitable	35 m/min	P
Steel < 900 N/mm²	suitable	22 m/min	P
Steel < 1100 N/mm²	suitable	12 m/min	P
Steel < 1400 N/mm²	suitable	7 m/min	P
INOX < 900 N/mm²	suitable	12 m/min	M
INOX > 900 N/mm²	suitable	10 m/min	M
CuZn	suitable only under restricted conditions	35 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		