

Garant
Machine tap for synchronised spindles HSS-E-PM Form C, TiAlN, M: M5

Order data

Order number	136171 M5
GTIN	4045197867506
Item class	11H

Description
Version:
Sturdy design with right-hand chip flutes and shank to DIN 1835-B.

Special geometry for **universal applications** on machines with **synchronised spindle drive**. The tap is guided by the synchronised spindle on the machine. Special **TiAlN-S coating** for optimum tool life.

For use 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: 0.8 mm

Overall length L: 70 mm

Shank $\varnothing D_s$: 6 mm

Tapping hole \varnothing : 4.2 mm

Technical description

Tool material	HSS E PM
Thread pitch	0.8 mm
Tapping hole \varnothing	4.2 mm
Standard	Manufacturer's standard
Number of clamping slots	3

Number of cutting edges Z	3
Thread Ø	5 mm
Tolerance class	ISO 2X 6HX
Shank Ø D _s	6 mm
Overall length L	70 mm
Thread depth	15 mm
Thread type	M
Thread size	M5
Coating	TiAlN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Helix angle	40°
Shank	DIN 1835 B to h6
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	green
Type of product	Tap

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	32 m/min	N
Aluminium (short chipping)	suitable	32 m/min	N
Steel < 500 N/mm ²	suitable	33 m/min	P

Steel < 750 N/mm ²	suitable	32 m/min	P
Steel < 900 N/mm ²	suitable	20 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
Steel < 1400 N/mm ²	suitable	7 m/min	P
INOX < 900 N/mm ²	suitable	11 m/min	M
INOX > 900 N/mm ²	suitable	9 m/min	M
CuZn	suitable only under restricted conditions	30 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		