

Garant**Machine tap HSS-E-PM, TiN / vaporised, MF: 6X0,75****Order data**

Order number	136290 6X0,75
GTIN	4045197883513
Item class	11H

Description**Version:****With special TiN coating and vaporised cutting surfaces.**

For controlled swarf evacuation and avoidance of clogging.

Especially suitable for problem materials.For use with **emulsion** (fat content minimum 8%).**Recommendation:**For **TOOLOX materials we recommend deviating from the DIN data** (see table) by drilling the tapping hole Ø **0.05 to 0.3 mm** larger.

Thread type: MF

Tool material: HSS E PM

Standard: DIN 374

Tolerance class: ISO 2 6H

Thread pitch: 0.75 mm

Overall length L: 80 mm

Shank Ø D_s: 4.5 mm

Shank square □: 3.4 mm

Tapping hole Ø: 5.2 mm

Technical description

Number of clamping slots	3
Overall length L	80 mm
Tolerance class	ISO 2 6H
Tool material	HSS E PM
Number of cutting edges Z	3

Standard	DIN 374
Thread Ø	6 mm
Shank square □	3.4 mm
Shank Ø D _s	4.5 mm
Tapping hole Ø	5.2 mm
Thread pitch	0.75 mm
Thread depth	18 mm
Thread type	MF
Thread size	M6×0.75
Coating	TiN / vaporised
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 °
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	red
Type of product	Tap

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	27 m/min	P
Steel < 750 N/mm ²	suitable	23 m/min	P
Steel < 900 N/mm ²	suitable	23 m/min	P
Steel < 1100 N/mm ²	suitable	13 m/min	P
Steel < 1400 N/mm ²	suitable	10 m/min	P

TOOLOX 33	suitable	12 m/min	H
Ti > 850 N/mm ²	suitable	5 m/min	S
Oil	suitable		
wet maximum	suitable		