

**Garant**
**GARANT Master Tap machine tap HSS-E-PM extra long Form C 6HX, AlTiX, M: M3**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 134680 M3     |
| GTIN         | 4045197899811 |
| Item class   | 11I           |

**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. **Shank to DIN 371.**

**Advantage:**

Designed for tapping threads where access is difficult.

**Technical description**

|                           |            |
|---------------------------|------------|
| Number of clamping slots  | 3          |
| Shank square □            | 2.7 mm     |
| Thread pitch              | 0.5 mm     |
| Tolerance class           | ISO 2X 6HX |
| Thread size               | M3         |
| Overall length L          | 100 mm     |
| Number of cutting edges Z | 3          |
| Thread Ø                  | 3 mm       |
| Thread type               | M          |
| Tapping hole Ø            | 2.5 mm     |

|                                  |                                   |
|----------------------------------|-----------------------------------|
| Standard                         | Manufacturer's standard           |
| Shank $\varnothing D_s$          | 3.5 mm                            |
| Tool material                    | HSS E PM                          |
| Thread depth                     | 7.5 mm                            |
| Coating                          | AlTiX                             |
| Flank angle                      | 60 degrees                        |
| Thread standard                  | DIN 13                            |
| 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                      | green                             |
| Series                           | Master Tap                        |
| Type of product                  | Tap                               |

## User data

|                                | Suitability | $V_c$    | 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 |          |   |