

Garant
GARANT Master Tap machine tap HSS-E-PM Form E 6HX, AlTiX, M: M4

Order data

| | |
|--------------|---------------|
| Order number | 136152 M4 |
| GTIN | 4045197900210 |
| Item class | 111 |

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.**

Form E (1.5-2 turns lead chamfer)

Thread type: M

Tool material: HSS E PM

Standard: DIN 371

Tolerance class: ISO 2X 6HX

Thread pitch: 0.7 mm

Overall length L: 63 mm

Shank $\varnothing D_s$: 4.5 mm

Shank square \square : 3.4 mm

Tapping hole \varnothing : 3.3 mm

Technical description

| | |
|----------------------------|------------|
| Tolerance class | ISO 2X 6HX |
| Number of clamping slots | 3 |
| Shank square \square | 3.4 mm |
| Thread \varnothing | 4 mm |
| Tapping hole \varnothing | 3.3 mm |
| Number of cutting edges Z | 3 |

| | |
|----------------------------------|-----------------------------------|
| Overall length L | 63 mm |
| Standard | DIN 371 |
| Thread pitch | 0.7 mm |
| Tool material | HSS E PM |
| Shank $\varnothing D_s$ | 4.5 mm |
| Thread depth | 10 mm |
| Thread type | M |
| Thread size | M4 |
| Coating | AlTiX |
| Flank angle | 60° |
| Thread standard | DIN 13 |
| Taper lead form | E |
| Helix angle | 40° |
| 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 | 22 m/min | N |
| Aluminium (short chipping) | suitable | 25 m/min | N |
| Alu > 10% Si | suitable | 15 m/min | N |
| Steel < 500 N/mm ² | suitable | 22 m/min | P |

| | | | |
|--------------------------------|----------|----------|---|
| Steel < 750 N/mm ² | suitable | 22 m/min | P |
| Steel < 900 N/mm ² | suitable | 18 m/min | P |
| Steel < 1100 N/mm ² | suitable | 8 m/min | P |
| Steel < 1400 N/mm ² | suitable | 6 m/min | P |
| INOX < 900 N/mm ² | suitable | 7 m/min | M |
| INOX > 900 N/mm ² | suitable | 6 m/min | M |
| GG(G) | suitable | 15 m/min | K |
| CuZn | suitable | 15 m/min | N |
| Uni | suitable | | |
| Oil | suitable | | |
| wet maximum | suitable | | |