**⁑ Hoffmann Group**

Garant

# GARANT Master Tap machine tap HSS-E-PM IC / Form C 6HX, AlTiX, M: M14

## Order data

| | |
|---|---|
| Order number | 135965 M14 |
| GTIN | 4045197899644 |
| 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 internal coolant feed.**
Thread type: M
Tool material: HSS E PM
Standard: DIN 376
Tolerance class: ISO 2X 6HX
Thread pitch: 2 mm
Overall length L: 110 mm
Shank Ø $D_s$: 11 mm
Shank square □: 9 mm
Tapping hole Ø: 12 mm

## Technical description

| | |
|---|---|
| Overall length L | 110 mm |
| Thread depth | 35 mm |
| Thread Ø | 14 mm |
| Tolerance class | ISO 2X 6HX |
| Thread pitch | 2 mm |
| Standard | DIN 376 |

| | |
|---|---|
| Shank Ø $D_s$ | 11 mm |
| Tapping hole Ø | 12 mm |
| Shank square □ | 9 mm |
| Tool material | HSS E PM |
| Number of cutting edges Z | 3 |
| Number of clamping slots | 3 |
| Thread type | M |
| Thread size | M14 |
| Coating | AlTiX |
| Flank angle | 60 ° |
| Thread standard | DIN 13 |
| Taper lead form | C |
| Helix angle | 40 ° |
| Shank | Plain shank with h9 |
| Through-coolant | yes |
| 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 | 30 m/min | N |
| Aluminium (short chipping) | suitable | 35 m/min | N |
| Alu > 10% Si | suitable | 20 m/min | N |
| Steel < 500 N/mm² | suitable | 30 m/min | P |

| | | | |
|---|---|---|---|
| Steel < 750 N/mm² | suitable | 30 m/min | P |
| Steel < 900 N/mm² | suitable | 25 m/min | P |
| Steel < 1100 N/mm² | suitable | 12 m/min | P |
| Steel < 1400 N/mm² | suitable | 8 m/min | P |
| INOX < 900 N/mm² | suitable | 10 m/min | M |
| INOX > 900 N/mm² | suitable | 8 m/min | M |
| GG(G) | suitable | 20 m/min | K |
| CuZn | suitable | 20 m/min | N |
| Uni | suitable | | |
| Oil | suitable | | |
| wet maximum | suitable | | |