Garant

GARANT Master Tap SteelHT machine tap HSS-E-PM Form B 6HX, TiCN, MF: 3X0,35

Order data

Order number	132855 3X0,35
GTIN	4062406236021
Item class	11l

Description

Version:
High-performance tap, specially developed for use in **steels with high tensile strength** and for **difficult-to-machine materials. Strong spiral point,** for process stability at high cutting forces.
· **HSS-E-PM tool material – for very high cutting edge stability.**
· **Optimised honed cutting edges.**
· **TiCN coating – for maximum wear protection.**
Recommendation:
For **TOOLOX and HARDOX materials we recommenddeviating from the DIN data** (see table) **by selecting a larger tapping hole** ∅.
Thread type: MF
Tool material: HSS E PM
Standard: DIN 374
Tolerance class: ISO 2X 6HX
Thread pitch: 0.35 mm
Overall length L: 56 mm
Shank ∅ D_s: 2.2 mm
Tapping hole ∅: 2.65 mm

Technical description

Thread depth	9 mm
Tool material	HSS E PM
Overall length L	56 mm
Thread ∅	3 mm

Tolerance class	ISO 2X 6HX
Thread type	MF
Thread pitch	0.35 mm
Standard	DIN 374
Number of cutting edges Z	3
Number of clamping slots	3
Tapping hole ∅	2.65 mm
Shank ∅ D_s	2.2 mm
Coating	TiCN
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Series	Master Tap
Type of product	Tap

User data

	Suitability	V_c	ISO code
Steel < 750 N/mm²	Suitable only under restricted conditions	30 m/min	P
Steel < 900 N/mm²	suitable	20 m/min	P
Steel < 1100 N/mm²	suitable	15 m/min	P
Steel < 1400 N/mm²	suitable	12 m/min	P
Steel < 50 HRC	Suitable only under restricted conditions		

TOOLOX 33	suitable	15 m/min	H
TOOLOX 44	suitable		
HARDOX 500 < 1600 N/mm²	suitable only under restricted conditions		
INOX > 900 N/mm²	suitable		
Ti > 850 N/mm²	suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		