

**Garant**
**GARANT Master Tap machine tap HSS-E-PM Form C 6GX, AlTiX, M: M2**

**Order data**

Order number	136158 M2
GTIN	4045197899712
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.**

**Tolerance class: ISO 3X/6GX**

**Application:**

For components which are galvanised or shrink slightly when hardened.

**Recommendation:**

We recommend increasing the size of the tapping hole  $\varnothing$  by the tolerance allowance.

Thread type: M

Tool material: HSS E PM

Standard: DIN 371

Tolerance class: ISO 3X 6GX

Thread pitch: 0.4 mm

Overall length L: 45 mm

Shank  $\varnothing D_s$ : 2.8 mm

Shank square  $\square$ : 2.1 mm

Tapping hole  $\varnothing$ : 1.6 mm

**Technical description**

Shank square $\square$	2.1 mm
Thread pitch	0.4 mm
Number of clamping slots	2
Tool material	HSS E PM

Thread depth	5 mm
Shank $\varnothing D_s$	2.8 mm
Overall length L	45 mm
Tapping hole $\varnothing$	1.6 mm
Number of cutting edges Z	2
Thread $\varnothing$	2 mm
Standard	DIN 371
Tolerance class	ISO 3X 6GX
Thread type	M
Thread size	M2
Coating	AlTiX
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 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/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	8 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	10 m/min	M
INOX > 900 N/mm <sup>2</sup>	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		