

Garant
Fluteless machine tap with oil grooves HSS-E-PM Form C 6HX, TiN, M: M6

Order data

Order number	139175 M6
GTIN	4045197509000
Item class	11H

Description
Version:

DIN 2174 ($\approx$ DIN 371 $\leq$ M10; $\approx$ DIN 376 $\geq$ M12). With oil grooves; optimum lubrication effect even in deeper threads.

Tolerance class: ISO 2X/6HX.

The **innovative polygon form** permits a wide application spectrum. The **multi-function layer structure** achieves **maximum service life** even in **high-tensile materials**.

Tolerance class: ISO 2X 6HX

Thread pitch: 1 mm

Overall length L: 80 mm

Shank $\varnothing D_s$: 6 mm

Shank square $\square$: 4.9 mm

Tapping hole $\varnothing$ guide value: 5.55 mm

Technical description

Number of cutting edges Z	5
Thread pitch	1 mm
Thread $\varnothing$	6 mm
Number of clamping slots	5
Shank $\varnothing D_s$	6 mm
Shank square $\square$	4.9 mm
Overall length L	80 mm
Tapping hole $\varnothing$ guide value	5.55 mm

Tolerance class	ISO 2X 6HX
Thread depth	18 mm
Thread size	M6
Coating	TiN
Thread type	M
Flank angle	60 °
Tool material	HSS E PM
Standard	DIN 2174
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Colour ring	blue
Type of product	Fluteless tap

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	32 m/min	P
Steel < 750 N/mm ²	suitable	27 m/min	P
Steel < 900 N/mm ²	suitable	22 m/min	P
Steel < 1100 N/mm ²	suitable	17 m/min	P
INOX < 900 N/mm ²	suitable	12 m/min	M
INOX > 900 N/mm ²	suitable	7 m/min	M
CuZn	suitable only under restricted conditions	22 m/min	N
Oil	suitable		

wet maximum

suitable