

Garant

GARANT Master Form Steel fluteless machine tap with oil grooves HSS-E-PM, TiAlN, UNF: 2-64



Order data

Order number	139495 2-64
GTIN	4062406706920
Item class	111

Description

Version:

The latest generation of **high-performance fluteless taps**, specially developed for **use in steel materials**.

- **Optimised polygon geometry for a lower torque.**
- **Multi-layer HIPIMS coating for high wear resistance.**
- **HSS-E-PM substrate for exceptional process reliability.**

DIN 2174 (\approx DIN 371 \leq 3/8; \approx DIN 376 \geq 7/16).

Form E (lead-in 1.5 – 2 turns). For deep threads with short lead-in. The thread is tapped almost to the bottom of the hole.

Application:

For UNF unified fine threads ASME–B1.1.

Technical description

Tapping hole \varnothing guide value	2 mm
Thread pitch	0.397 mm
Number of cutting edges Z	3
Shank \varnothing D _s	2.8 mm
Number of clamping slots	3
Thread \varnothing	2.18 mm
Shank square \square	2.1 mm
Thread depth	6.54 mm

Overall length L	45 mm
Threads per inch	64
Coating	TiAlN
Thread type	UNF
Flank angle	60 degrees
Tool material	HSS E PM
Standard	DIN 2174
Tolerance class	2BX
Taper lead form	E
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
Series	Master Form
Type of product	Fluteless tap

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable	38 m/min	N
Steel < 500 N/mm ²	suitable	37 m/min	P
Steel < 750 N/mm ²	suitable	35 m/min	P
Steel < 900 N/mm ²	suitable	27 m/min	P
Steel < 1100 N/mm ²	suitable	18 m/min	P
Steel < 1400 N/mm ²	suitable	12 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	22 m/min	N

Oil	suitable
wet maximum	suitable
wet minimum	suitable