

Garant**GARANT Master Tap machine tap HSS-E-PM Form C, AlTiX, M: M1****Order data**

Order number	135960 M1
GTIN	4062406208745
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.**

Corresponds to **ISO 1X/4HX**.

Thread type: M

Tool material: HSS E PM

Standard: DIN 371

Tolerance class: ISO 1X 4HX

Thread pitch: 0.25 mm

Overall length L: 40 mm

Shank Ø D_s: 2.5 mm

Shank square □: 2.1 mm

Tapping hole Ø: 0.75 mm

Technical description

Tapping hole Ø	0.75 mm
Number of clamping slots	2
Standard	DIN 371
Shank square □	2.1 mm
Number of cutting edges Z	2
Thread Ø	1 mm

Tool material	HSS E PM
Tolerance class	ISO 1X 4HX
Thread type	M
Overall length L	40 mm
Thread depth	2.5 mm
Thread pitch	0.25 mm
Shank Ø D _s	2.5 mm
Thread size	M1
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 ²	suitable	30 m/min	P

Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
Steel < 1400 N/mm ²	suitable	8 m/min	P
INOX < 900 N/mm ²	suitable	10 m/min	M
INOX > 900 N/mm ²	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		