

**Garant**
**Synchronised fluteless machine tap with oil grooves Solid carbide, TiAlN, M: M2,5**

**Order data**

Order number	139242 M2,5
GTIN	4045197705853
Item class	11H

**Description**
**Version:**

**Special polygon geometry and shank to DIN 6535-HA** for use on machines with **synchronised spindle drives. With oil grooves; optimal lubrication effect even in deeper threads.**

**Special solid carbide tool material** for high cutting speeds and long tool life. **TiAlN and anti-friction coating** ensure low wear and low tendency to edge build-up.

**Note:**

**For use on synchronised spindles,** the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures very high process reliability.

Tolerance class: ISO 2X 6HX

Thread pitch: 0.45 mm

Overall length L: 50 mm

Shank  $\varnothing D_s$ : 6 mm

Shank square  $\square$ : 4.9 mm

Tapping hole  $\varnothing$  guide value: 2.3 mm

**Technical description**

Number of cutting edges Z	4
Number of clamping slots	4
Thread $\varnothing$	2.5 mm
Thread pitch	0.45 mm
Shank $\varnothing D_s$	6 mm

Shank square □	4.9 mm
Overall length L	50 mm
Tapping hole Ø guide value	2.3 mm
Tolerance class	ISO 2X 6HX
Thread depth	7.5 mm
Thread size	M2.5
Coating	TiAlN
Thread type	M
Flank angle	60 °
Tool material	Solid carbide
Standard	Manufacturer's standard
Thread standard	DIN 13
Taper lead form	C
Shank	DIN 6535 HA with h6
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
Shank tolerance	h6
Colour ring	without
Type of product	Fluteless tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	50 m/min	N
Aluminium (short chipping)	suitable	50 m/min	N
Alu > 10% Si	suitable only under restricted conditions	48 m/min	N

Steel < 500 N/mm <sup>2</sup>	suitable	52 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	48 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	45 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	33 m/min	P
Oil	suitable		
wet maximum	suitable		