

**GARANT Master Form Steel fluteless machine tap with oil grooves HSS-E-PM Form C 7GX, TiAlN, M: M10****Order data**

Order number	139207 M10
GTIN	4062406383664
Item class	11I

Description**Version:**

DIN 2174 ($\approx$ DIN 371 $\leq$ M10; $\approx$ DIN 376 $\geq$ M12).

Tolerance class: 7GX.

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.**

Application:

For components which are **galvanised**, or shrink slightly when hardened.

Technical description

Thread Ø	10 mm
Number of clamping slots	6
Overall length L	100 mm
Tolerance class	7GX
Thread depth	30 mm
Thread pitch	1.5 mm
Number of cutting edges Z	6
Shank Ø D _s	10 mm

Data sheet

Series	GARANT Master
Thread size	M10
Tapping hole Ø guide value	9.35 mm
Shank square □	8 mm
Coating	TiAlN
Thread type	M
Flank angle	60 degrees
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	without
Type of product	Fluteless tap

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	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

Data sheet

INOX > 900 N/mm ²	suitable	7 m/min	M
CuZn	suitable	22 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		