

Garant
GARANT Master Form Steel fluteless machine tap with oil grooves HSS-E-PM Form C 6HX, TiAlN, M: M14

Order data

Order number	139194 M14
GTIN	4062406383336
Item class	11I

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

Tolerance class: ISO 2X/6HX.

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.**

Technical description

Shank $\varnothing D_s$	11 mm
Thread depth	42 mm
Series	GARANT Master
Number of clamping slots	8
Shank square $\square$	9 mm
Tapping hole $\varnothing$ guide value	13.1 mm
Thread $\varnothing$	14 mm
Thread pitch	2 mm
Number of cutting edges Z	8
Overall length L	110 mm

Tolerance class	ISO 2X 6HX
Thread size	M14
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	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