Garant

Machine tap for synchronised spindles HSS-E-PM Form E, TiAIN, M: M3

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Order data

Order number	135415 M3
GTIN	4045197507884
Item class	11H

Description

Version:

Sturdy version with right-hand helix and shank to DIN 1835-B. Special geometry for use on machines with **synchronised spindle drives.** The tap is guided by the synchronised spindle on the machine. Special **TiAIN-S coating** for optimum tool life. For use with **emulsion** (fat content minimum 8%).

Form E (lead chamfer: 1.5 - 2 turns) for the deepest possible thread depths.

Recommendation:

For **TOOLOX materials** we recommend **deviating from the DIN** data (see table) by drilling the tapping hole \emptyset **0.05 to 0.3mm** larger.

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.

Thread type: M Tool material: HSS E PM Standard: Manufacturer's standard Tolerance class: ISO 2X 6HX Thread pitch: 0.5 mm Overall length L: 70 mm Shank \emptyset D_s: 6 mm Shank square \Box : 4.9 mm Tapping hole \emptyset : 2.5 mm

Technical description

Thread pitch	0.5 mm
Tapping hole Ø	2.5 mm
Thread Ø	3 mm

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StandardManufacturer's standardShank Ø D,6 mmOverall length L70 mmOverall length L70 mmShank square □4.9 mmTolerance classISO 2X 6HXTool materialHSS E PMTool material7.5 mmThread depth7.5 mmThread sizeM3CoatingTiAINFlank angle60 degreesThread standardDIN 13Taper lead formEHelix angle40 degreesShankDIN 1835 B to h6Through-coolantnoApplication for type of drillingup to 2.5×D for blind holesCutting directionright-hand	Number of clamping slots	3
Shank Ø D,6 mmOverall length L70 mmShank square □4.9 mmShank square □1SO 2X 6HXTolerance classISO 2X 6HXTool materialMSS E PMThread depth7.5 mmThread typeMThread sizeM3CoatingTiAINFlank angle60 degreesThread standardDIN 13Taper lead formEHelix angle40 degreesShankDIN 1835 B to h6Through-coolantnoApplication for type of drillingup to 2.5×D for blind holesCutting directionright-handShank toleranceh6	Number of cutting edges Z	3
Overall length L70 mmShank square □4.9 mmTolerance classISO 2X 6HXTool materialHSS E PMThread depth7.5 mmThread typeMThread sizeM3CoatingTiAlNFlank angle60 degreesThread standardDIN 13Taper lead form40 degreesHelix angleOIN 1835 B to h6Through-coolantnoApplication for type of drillingup to 2.5×D for blind holesCutting directionright-handShank toleranceh6	Standard	Manufacturer's standard
Shank square4.9 mmTolerance classISO 2X 6HXTool materialHSS E PMTool material7.5 mmThread depth7.5 mmThread typeMThread sizeM3CoatingTiAINFlank angle60 degreesThread standardDIN 13Taper lead formEHelix angle40 degreesShankDIN 1835 B to h6Through-coolantnoApplication for type of drillingup to 2.5×D for blind holesShank toleranceh6	Shank Ø D _s	6 mm
Tolerance classISO 2X 6HXTool materialHSS E PMThread depth7.5 mmThread typeMThread sizeM3CoatingTiAlNFlank angle60 degreesThread standardDIN 13Taper lead formEHelix angle40 degreesShankDIN 1835 B to h6Through-coolantnoApplication for type of drillingup to 2.5×D for blind holesCutting directionright-handShank toleranceh6	Overall length L	70 mm
Tool materialHSS E PMThread depth7.5 mmThread typeMThread sizeM3CoatingTiAINFlank angle60 degreesThread standardDIN 13Taper lead formEHelix angle40 degreesShankDIN 1835 B to h6Through-coolantnoApplication for type of drillingup to 2.5×D for blind holesShank tolerancefight-hand	Shank square 🗆	4.9 mm
Thread depth7.5 mmThread typeMThread sizeM3CoatingTiAINFlank angle60 degreesThread standardDIN 13Taper lead form40 degreesHelix angleJIN 1835 B to h6ShankDIN 1835 B to h6Through-coolantup to 2.5×D for blind holesApplication for type of drillingright-handShank toleranceh6	Tolerance class	ISO 2X 6HX
Thread typeMThread sizeM3CoatingTiAINCoating60 degreesFlank angle60 degreesThread standardDIN 13Taper lead form40 degreesHelix angleDIN 1835 B to h6ShankDIN 1835 B to h6Through-coolantup to 2.5×D for blind holesCutting directionright-handShank toleranceh6	Tool material	HSS E PM
Thread sizeM3CoatingTiAINFlank angle60 degreesThread standardDIN 13Taper lead formEHelix angle40 degreesShankDIN 1835 B to h6Through-coolantnoApplication for type of drillingup to 2.5×D for blind holesCutting directionright-handShank toleranceh6	Thread depth	7.5 mm
CoatingTiAlNFlank angle60 degreesThread standardDIN 13Taper lead formEHelix angle40 degreesShankDIN 1835 B to h6Through-coolantup to 2.5×D for blind holesApplication for type of drillingup to 2.5×D for blind holesShank toleranceh6	Thread type	М
Flank angle60 degreesThread standardDIN 13Taper lead formEHelix angle40 degreesShankDIN 1835 B to h6Through-coolantnoApplication for type of drillingup to 2.5×D for blind holesCutting directionright-handShank toleranceh6	Thread size	M3
Thread standardDIN 13Taper lead formEHelix angle40 degreesShankDIN 1835 B to h6Through-coolantnoApplication for type of drillingup to 2.5×D for blind holesCutting directionright-handShank toleranceh6	Coating	TiAIN
Taper lead formEHelix angle40 degreesShankDIN 1835 B to h6Through-coolantnoApplication for type of drillingup to 2.5×D for blind holesCutting directionfight-handShank toleranceh6	Flank angle	60 degrees
Helix angle40 degreesShankDIN 1835 B to h6Through-coolantnoApplication for type of drillingup to 2.5×D for blind holesCutting directionright-handShank toleranceh6	Thread standard	DIN 13
ShankDIN 1835 B to h6Through-coolantnoApplication for type of drillingup to 2.5×D for blind holesCutting directionright-handShank toleranceh6	Taper lead form	E
Through-coolantnoApplication for type of drillingup to 2.5×D for blind holesCutting directionright-handShank toleranceh6	Helix angle	40 degrees
Application for type of drillingup to 2.5×D for blind holesCutting directionright-handShank toleranceh6	Shank	DIN 1835 B to h6
Cutting directionright-handShank toleranceh6	Through-coolant	no
Shank tolerance h6	Application for type of drilling	up to 2.5×D for blind holes
	Cutting direction	right-hand
	Shank tolerance	h6
Type of threading toolMachine tap forsynchronous machining	Type of threading tool	Machine tap for synchronous machining
Colour ring red	Colour ring	red
Type of product Tap	Type of product	Тар