

**Garant**
**Machine tap for synchronised spindles HSS-E-PM Form E, TiAlN, M: M5**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 135415 M5     |
| GTIN         | 4045197507907 |
| 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 **TiAlN-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  $\varnothing$  **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: 0.8 mm

Overall length L: 70 mm

Shank  $\varnothing$  D<sub>s</sub>: 6 mm

Shank square □: 4.9 mm

Tapping hole  $\varnothing$ : 4.2 mm

**Technical description**

|                            |        |
|----------------------------|--------|
| Thread $\varnothing$       | 5 mm   |
| Tapping hole $\varnothing$ | 4.2 mm |
| Number of cutting edges Z  | 3      |

|                                  |                                       |
|----------------------------------|---------------------------------------|
| Number of clamping slots         | 3                                     |
| Thread pitch                     | 0.8 mm                                |
| Standard                         | Manufacturer's standard               |
| Shank $\varnothing D_s$          | 6 mm                                  |
| Overall length L                 | 70 mm                                 |
| Shank square $\square$           | 4.9 mm                                |
| Tolerance class                  | ISO 2X 6HX                            |
| Tool material                    | HSS E PM                              |
| Thread depth                     | 12.5 mm                               |
| Thread type                      | M                                     |
| Thread size                      | M5                                    |
| Coating                          | TiAlN                                 |
| Flank angle                      | 60 degrees                            |
| Thread standard                  | DIN 13                                |
| Taper lead form                  | E                                     |
| Helix angle                      | 40 degrees                            |
| Shank                            | DIN 1835 B to h6                      |
| Through-coolant                  | no                                    |
| Application for type of drilling | up to 2.5×D for blind holes           |
| Cutting direction                | right-hand                            |
| Shank tolerance                  | h6                                    |
| Type of threading tool           | Machine tap for synchronous machining |
| Colour ring                      | red                                   |
| Type of product                  | Tap                                   |