

Garant
GARANT Master Tap INOX machine tap HSS-E-PM, TiAlN, MF: 18X1,5

Order data

Order number	132875 18X1,5
GTIN	4062406081058
Item class	111

Description
Version:
GARANT Master Tap INOX:

Powerful tap, specially developed for **tapping to high process reliability in stainless and acid-resistant steels** and also **duplex materials**.

- **HSS-E-PM tool material for maximum wear resistance**
- **The latest generation of TiAlN multi-layer coating**
- **Parameterised flute geometry for optimum chip formation and torsional rigidity**

Thread type: MF

Tool material: HSS E PM

Standard: DIN 374

Tolerance class: ISO 2X 6HX

Thread pitch: 1.5 mm

Overall length L: 110 mm

Shank Ø D_s: 14 mm

Shank square □: 11 mm

Tapping hole Ø: 16.5 mm

Technical description

Tapping hole Ø	16.5 mm
Tool material	HSS E PM
Thread pitch	1.5 mm
Thread type	MF
Thread Ø	18 mm

Shank $\varnothing D_s$	14 mm
Shank square \square	11 mm
Number of clamping slots	4
Overall length L	110 mm
Standard	DIN 374
Thread depth	54 mm
Tolerance class	ISO 2X 6HX
Number of cutting edges Z	4
Thread size	M18x1.5
Coating	TiAlN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3xD for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	blue
Series	Master Tap
Type of product	Tap

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	28 m/min	N
Steel < 750 N/mm ²	suitable only under restricted conditions	23 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	23 m/min	P

Steel < 1100 N/mm ²	suitable	12 m/min	P
INOX < 900 N/mm ²	suitable	11 m/min	M
INOX > 900 N/mm ²	suitable	9 m/min	M
Oil	suitable		
wet maximum	suitable		