

**Garant**
**GARANT Master Tap INOX machine tap HSS-E-PM Form E 6HX, TiAlN, M: M24**

**Order data**

Order number	135736 M24
GTIN	4062406081669
Item class	111

**Description**
**Version:**

High-performance tap, specially developed for **good process reliability in stainless and acid-resistant steels** and **duplex materials**.

**The 45° helix angle** of the flutes facilitates chip formation especially in ductile austenitic CrNi steels.

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

Form E (lead chamfer: 1.5 - 2 turns).

Thread type: M

Tool material: HSS E PM

Standard: DIN 376

Tolerance class: ISO 2X 6HX

Thread pitch: 3 mm

Overall length L: 160 mm

Shank Ø D<sub>s</sub>: 18 mm

Shank square □: 14.5 mm

Tapping hole Ø: 21 mm

**Technical description**

Tolerance class	ISO 2X 6HX
Number of cutting edges Z	4
Shank square □	14.5 mm
Thread depth	60 mm

Thread pitch	3 mm
Thread type	M
Standard	DIN 376
Tool material	HSS E PM
Thread Ø	24 mm
Tapping hole Ø	21 mm
Overall length L	160 mm
Number of clamping slots	4
Shank Ø D <sub>s</sub>	18 mm
Thread size	M24
Coating	TiAlN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	E
Helix angle	45°
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D 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 <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	28 m/min	N

Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	23 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	23 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	11 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	9 m/min	M
Oil	suitable		
wet maximum	suitable		