

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

Order data

Order number	137053 18X1,5
GTIN	4062406081799
Item class	111

Description
Version:
GARANT Master Tap INOX:

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**

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 $\varnothing D_s$: 14 mm

Shank square \square : 11 mm

Tapping hole \varnothing : 16.5 mm

Technical description

Number of clamping slots	4
Shank $\varnothing D_s$	14 mm
Thread type	MF
Tapping hole \varnothing	16.5 mm

Tool material	HSS E PM
Thread Ø	18 mm
Tolerance class	ISO 2X 6HX
Standard	DIN 374
Shank square □	11 mm
Number of cutting edges Z	4
Overall length L	110 mm
Thread depth	45 mm
Thread pitch	1.5 mm
Thread size	M18×1.5
Coating	TiAlN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
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 _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		