

Garant
GARANT Master Tap INOX machine tap HSS-E-PM, TiAlN, MF: 22X1,5

Order data

Order number	137053 22X1,5
GTIN	4062406081812
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: 125 mm

Shank $\varnothing D_s$: 18 mm

Shank square \square : 14.5 mm

Tapping hole \varnothing : 20.5 mm

Technical description

Thread pitch	1.5 mm
Standard	DIN 374
Shank $\varnothing D_s$	18 mm
Tool material	HSS E PM

Thread Ø	22 mm
Tapping hole Ø	20.5 mm
Thread depth	55 mm
Shank square □	14.5 mm
Number of cutting edges Z	5
Number of clamping slots	5
Overall length L	125 mm
Thread type	MF
Tolerance class	ISO 2X 6HX
Thread size	M22×1.5
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		