



Machine tap HSS-E, vaporised, M: M24



Order data

Order number	132645 M24
GTIN	4062406088163
Item class	12H

Description

Version:

Spiral point with oil grooves.

Guide section with oil grooves, but without chip flutes.

Thread type: M

Tool material: HSS E

Standard: DIN 376

Tolerance class: ISO 2 6H

Thread pitch: 3 mm

Overall length L: 160 mm

Shank $\varnothing D_s$: 18 mm

Shank square \square : 14.5 mm

Tapping hole \varnothing : 21 mm

Technical description

Thread \varnothing	24 mm
Tolerance class	ISO 2 6H
Overall length L	160 mm
Shank $\varnothing D_s$	18 mm
Thread type	M
Thread pitch	3 mm
Number of cutting edges Z	3
Shank square \square	14.5 mm

Tool material	HSS E
Number of clamping slots	3
Tapping hole Ø	21 mm
Thread depth	72 mm
Standard	DIN 376
Thread size	M24
Coating	vaporised
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 3×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Type of product	Tap

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	11 m/min	N
Steel < 500 N/mm ²	suitable only under restricted conditions	12 m/min	P
Steel < 750 N/mm ²	suitable	8 m/min	P
Steel < 900 N/mm ²	suitable	7 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	4 m/min	P
INOX < 900 N/mm ²	suitable	4 m/min	M

CuZn	suitable only under restricted conditions	12 m/min	N
Uni	suitable		
Oil	suitable		