

**Garant**
**Machine tap, TiCN, MF: 14X1,5**

**Order data**

Order number	132861 14X1,5
GTIN	4045197745750
Item class	11H

**Description**
**Version:**
**Sturdy version.**
**Recommendation:**

For **very hard steels, TOOLOX and HARDOX materials** we recommend **deviating from the DIN data** (see table) by **drilling the core hole  $\varnothing$  0.05 to 0.3 mm** larger. For use only with a length compensation chuck – even on machines with synchronised spindle drives.

Thread type: MF

Tool material: HSS E PM

Standard: DIN 374

Tolerance class: ISO 2X 6HX

Thread pitch: 1.5 mm

Overall length L: 100 mm

 Shank  $\varnothing$  D<sub>s</sub>: 11 mm

 Shank square  $\square$ : 9 mm

 Tapping hole  $\varnothing$ : 12.5 mm

**Technical description**

Shank $\varnothing$ D <sub>s</sub>	11 mm
Thread $\varnothing$	14 mm
Tool material	HSS E PM
Tapping hole $\varnothing$	12.5 mm
Number of cutting edges Z	5
Shank square $\square$	9 mm

Overall length L	100 mm
Number of clamping slots	5
Thread pitch	1.5 mm
Tolerance class	ISO 2X 6HX
Standard	DIN 374
Thread depth	21 mm
Thread type	MF
Thread size	M14×1.5
Coating	TiCN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 1.5×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	red
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	7 m/min	P
Steel < 55 HRC	suitable	2 m/min	H
TOOLOX 33	suitable	4 m/min	H
TOOLOX 44	suitable	3 m/min	H
HARDOX 500 < 1600 N/mm <sup>2</sup>	suitable	2 m/min	H

Graphite	suitable only under restricted conditions	15 m/min	N
Oil	suitable		