

**Garant**
**Machine tap HSS-E-PM, TiN / vaporised, M: M27**

**Order data**

Order number	135375 M27
GTIN	4045197747211
Item class	11H

**Description**
**Version:**

For use with **emulsion** (fat content minimum 8%).

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**Recommendation:**

For **TOOLOX** and **HARDOX materials** we recommend **deviating from the DIN data** (see table) by drilling the tapping hole  $\varnothing$  **0.05** to **0.3 mm** larger.

Thread type: M

Tool material: HSS E PM

Standard: DIN 376

Tolerance class: ISO 2 6H

Thread pitch: 3 mm

Overall length L: 160 mm

Shank  $\varnothing$  D<sub>s</sub>: 20 mm

Shank square □: 16 mm

Tapping hole  $\varnothing$ : 24 mm

**Technical description**

Tolerance class	ISO 2 6H
Number of cutting edges Z	4
Overall length L	160 mm
Shank square □	16 mm
Thread $\varnothing$	27 mm
Tapping hole $\varnothing$	24 mm

Shank $\varnothing D_s$	20 mm
Number of clamping slots	4
Tool material	HSS E PM
Thread pitch	3 mm
Standard	DIN 376
Thread depth	81 mm
Thread type	M
Thread size	M27
Coating	TiN / vaporised
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Helix angle	40°
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	red
Type of product	Tap

## User data

	Suitability	$V_c$	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	27 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	23 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	23 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	13 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	10 m/min	P
TOOLOX 33	suitable	12 m/min	H

Ti > 850 N/mm <sup>2</sup>	suitable	5 m/min	S
Oil	suitable		
wet maximum	suitable		