

## Garant

### GARANT Master Tap machine tap left-hand thread HSS-E-PM 6HX, AlTiX, M-LH: M24



#### Order data

Order number	136190 M24
GTIN	4062406207960
Item class	111

#### Description

##### Version:

**Universal taps**, designed for use in a wide spectrum of materials with high process reliability.

- **HSS-E-PM tool material for a high degree of wear resistance.**
- **Reduced coefficient of friction due to the new high-performance coating.**
- **Special geometry for optimum swarf evacuation.**

Thread type: M-LH

Tool material: HSS E PM

Standard: DIN 376

Tolerance class: ISO 2X 6HX

Thread pitch: 3 mm

Overall length L: 160 mm

Shank Ø D<sub>s</sub>: 18 mm

Shank square □: 14.5 mm

Tapping hole Ø: 21 mm

#### Technical description

Tolerance class	ISO 2X 6HX
Tapping hole Ø	21 mm
Tool material	HSS E PM
Thread depth	60 mm
Thread type	M-LH
Number of cutting edges Z	4

Thread Ø	24 mm
Shank square □	14.5 mm
Number of clamping slots	4
Thread pitch	3 mm
Standard	DIN 376
Shank Ø D <sub>s</sub>	18 mm
Overall length L	160 mm
Thread size	M24 LH
Coating	AlTiX
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 2.5×D for blind holes
Cutting direction	left-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Series	Master Tap
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	30 m/min	N
Aluminium (short chipping)	suitable	35 m/min	N
Alu > 10% Si	suitable	20 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	30 m/min	P

Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	8 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	10 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	8 m/min	M
GG(G)	suitable	20 m/min	K
CuZn	suitable	20 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		