

Garant

GARANT Master Tap SteelHT machine tap HSS-E-PM Form B 6HX, TiCN, MF: 18X1,5



Order data

Order number	132855 18X1,5
GTIN	4062406236649
Item class	11I

Description

Version:

High-performance tap, specially developed for use in **steels with high tensile strength** and for **difficult-to-machine materials. Strong spiral point**, for process stability at high cutting forces.

- **HSS-E-PM tool material – for very high cutting edge stability.**
- **Optimised honed cutting edges.**
- **TiCN coating – for maximum wear protection.**

Recommendation:

For **TOOLOX** and **HARDOX** materials we recommend **deviating from the DIN data** (see table) by selecting a larger tapping hole \varnothing .

Technical description

Shank $\varnothing D_s$	14 mm
Tapping hole \varnothing	16.5 mm
Shank square \square	11 mm
Thread pitch	1.5 mm
Tool material	HSS E PM
Standard	DIN 374
Number of clamping slots	4
Tolerance class	ISO 2X 6HX
Number of cutting edges Z	4

Thread type	MF
Thread depth	54 mm
Thread Ø	18 mm
Overall length L	110 mm
Coating	TiCN
Flank angle	60 degrees
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	red
Series	Master Tap
Type of product	Tap

User data

	Suitability	V _c	ISO code
Steel < 750 N/mm ²	Suitable only under restricted conditions	30 m/min	P
Steel < 900 N/mm ²	suitable	20 m/min	P
Steel < 1100 N/mm ²	suitable	15 m/min	P
Steel < 1400 N/mm ²	suitable	12 m/min	P
Steel < 50 HRC	Suitable only under restricted conditions		
TOOLOX 33	suitable	15 m/min	H
TOOLOX 44	suitable		
HARDOX 500 < 1600 N/mm ²	suitable only under restricted conditions		

INOX > 900 N/mm ²	suitable
Ti > 850 N/mm ²	suitable only under restricted conditions
Oil	suitable
wet maximum	suitable