

Garant

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



Order data

Order number	136350 18X1,5
GTIN	4062406237387
Item class	11I

Description

Version:

High-performance tap, specially developed for use in **steels with high tensile strength** and for **difficult-to-machine materials**. Sturdy design with **optimised guide thread to avoid chips jamming**.

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

Recommendation:

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

Note:

For **TOOLOX materials**: do not exceed the maximum thread depth of $2 \times D!$

Technical description

Tolerance class	ISO 2X 6HX
Shank $\varnothing D_s$	14 mm
Thread type	MF
Thread size	M18x1.5
Tool material	HSS E PM
Standard	DIN 374
Shank square \square	11 mm

Thread pitch	1.5 mm
Tapping hole Ø	16.5 mm
Thread Ø	18 mm
Thread depth	45 mm
Overall length L	110 mm
Number of cutting edges Z	4
Number of clamping slots	4
Coating	TiAlN
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2xD for blind 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		

Steel < 50 HRC	Suitable only under restricted conditions		
TOOLOX 33	suitable	15 m/min	H
TOOLOX 44	suitable		
INOX > 900 N/mm ²	suitable		
Ti > 850 N/mm ²	Suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		