

Garant
GARANT Master Tap SteelHT machine tap HSS-E-PM Form B 6HX, TiCN, MF: 24X1,5

Order data

| | |
|--------------|---------------|
| Order number | 132855 24X1,5 |
| GTIN | 4062406236670 |
| 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

| | |
|----------------------------|------------|
| Standard | DIN 374 |
| Shank $\varnothing D_s$ | 18 mm |
| Tapping hole \varnothing | 22.5 mm |
| Tolerance class | ISO 2X 6HX |
| Number of clamping slots | 4 |
| Number of cutting edges Z | 4 |
| Overall length L | 140 mm |
| Shank square \square | 14.5 mm |
| Thread depth | 72 mm |

| | |
|----------------------------------|-----------------------------------|
| Thread Ø | 24 mm |
| Thread type | MF |
| Thread pitch | 1.5 mm |
| Tool material | HSS E PM |
| 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 |