

Garant
GARANT Master Tap machine tap Form B, ALTiX, M: M18

Order data

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| Order number | 132721 M18 |
| GTIN | 4062406266516 |
| 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.**

Corresponds to **ISO 2X/6HX**.

Technical description

| | |
|---------------------------------------|--------------|
| Tool material | HSS E PM |
| Shank square <input type="checkbox"/> | 11 mm |
| Overall length L | 125 mm |
| Thread \varnothing | 18 mm |
| Thread depth | 54 mm |
| Thread size | ASCD18-300W2 |
| Tolerance class | ISO 2X 6HX |
| Thread type | M |
| Number of clamping slots | 4 |
| Number of cutting edges Z | 4 |
| Tapping hole \varnothing | 15.5 mm |
| Thread pitch | 2.5 mm |

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|----------------------------------|-----------------------------------|
| Standard | DIN 376 |
| Shank $\varnothing D_s$ | 14 mm |
| Coating | AlTiX |
| 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 | green |
| Series | Master Tap |
| Type of product | Tap |

User data

| | Suitability | V_c | 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 ² | suitable | 30 m/min | P |
| Steel < 750 N/mm ² | suitable | 30 m/min | P |
| Steel < 900 N/mm ² | suitable | 25 m/min | P |
| Steel < 1100 N/mm ² | suitable | 12 m/min | P |
| Steel < 1400 N/mm ² | suitable | 8 m/min | P |
| INOX < 900 N/mm ² | suitable | 10 m/min | M |
| INOX > 900 N/mm ² | 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 | | |