

**Garant**
**Fluteless machine tap with oil grooves HSS-E-PM, TiN, MF: 20X1,5**

**Order data**

Order number	139260 20X1,5
GTIN	4045197509512
Item class	11H

**Description**
**Version:**

The **innovative polygon form** for a wide application spectrum. Particularly suitable for nickel-chrome steels.

**Satisfies DIN 374.**

Tolerance class: ISO 2X 6HX

Thread pitch: 1.5 mm

Overall length L: 125 mm

Shank  $\varnothing D_s$ : 16 mm

Shank square  $\square$ : 12 mm

Tapping hole  $\varnothing$  guide value: 19.35 mm

**Technical description**

Number of clamping slots	8
Number of cutting edges Z	8
Thread $\varnothing$	20 mm
Shank $\varnothing D_s$	16 mm
Shank square $\square$	12 mm
Overall length L	125 mm
Tapping hole $\varnothing$ guide value	19.35 mm
Thread depth	60 mm
Thread pitch	1.5 mm

Tolerance class	ISO 2X 6HX
Thread size	M20×1.5
Coating	TiN
Thread type	MF
Flank angle	60°
Tool material	HSS E PM
Standard	DIN 2174
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Colour ring	blue
Type of product	Fluteless tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	32 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	27 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	22 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	17 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	12 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	7 m/min	M
CuZn	suitable	22 m/min	N
Oil	suitable		
wet maximum	suitable		

