

Garant
Machine tap HSS-E, vaporised, M: M22

Order data

Order number	132640 M22
GTIN	4045197072429
Item class	11H

Description
Version:

Guide section with oil grooves, but without chip flutes.

Size M1.7, M2.3, and M2.6 with old DIN profile.

With spiral point. Tolerance class: ISO 2 6H

Technical description

Number of clamping slots	4
Thread \varnothing	22 mm
Number of cutting edges Z	4
Tapping hole \varnothing	19.5 mm
Thread pitch	2.5 mm
Standard	DIN 376
Shank $\varnothing D_s$	18 mm
Overall length L	140 mm
Shank square \square	14.5 mm
Tolerance class	ISO 2 6H
Tool material	HSS E
Thread depth	66 mm
Thread type	M
Thread size	M22

Coating	vaporised
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
Type of product	Tap

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	13 m/min	N
Steel < 500 N/mm ²	suitable	15 m/min	P
Steel < 750 N/mm ²	suitable	15 m/min	P
Steel < 900 N/mm ²	suitable	15 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	6 m/min	P
INOX < 900 N/mm ²	suitable	6 m/min	M
CuZn	suitable only under restricted conditions	13 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable only under restricted conditions		