

**Garant**
**Machine tap HSS-E, vaporised, M: M27**

**Order data**

Order number	132640 M27
GTIN	4045197072443
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 cutting edges Z	4
Thread pitch	3 mm
Thread $\varnothing$	27 mm
Number of clamping slots	4
Tapping hole $\varnothing$	24 mm
Standard	DIN 376
Shank $\varnothing D_s$	20 mm
Overall length L	160 mm
Shank square $\square$	16 mm
Tolerance class	ISO 2 6H
Tool material	HSS E
Thread depth	81 mm
Thread type	M
Thread size	M27

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 <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	13 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	6 m/min	P
INOX < 900 N/mm <sup>2</sup>	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		