

**Garant**
**Machine tap HSS-E Form B, uncoated, MF: 22X1,5**

**Order data**

Order number	132830 22X1,5
GTIN	4045197073242
Item class	11H

**Description**
**Version:**
**With spiral point.**

Thread type: MF

Tool material: HSS E

Standard: DIN 374

Tolerance class: ISO 2 6H

Thread pitch: 1.5 mm

Overall length L: 125 mm

 Shank  $\varnothing D_s$ : 18 mm

 Shank square  $\square$ : 14.5 mm

 Tapping hole  $\varnothing$ : 20.5 mm

**Technical description**

Tapping hole $\varnothing$	20.5 mm
Number of cutting edges Z	3
Thread pitch	1.5 mm
Thread $\varnothing$	22 mm
Number of clamping slots	3
Shank $\varnothing D_s$	18 mm
Overall length L	125 mm
Shank square $\square$	14.5 mm
Tolerance class	ISO 2 6H

Tool material	HSS E
Standard	DIN 374
Thread depth	66 mm
Thread type	MF
Thread size	M22×1.5
Coating	uncoated
Flank angle	60°
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 conventional machining
Colour ring	without
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
Oil	suitable		
wet maximum	suitable only under restricted conditions		