

Garant
Machine tap HSS-E-PM Form CS, TiN, MF: 22X1,5

Order data

Order number	132835 22X1,5
GTIN	4045197073617
Item class	11H

Description
Version:
With spiral point.

(Form CS) 2 – 3 – start chamfer lead – with spiral point.

TiN coated.

 Can be used with **soluble coolant** (fat content min. 8 %).

Thread type: MF

Tool material: HSS E PM

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

Thread pitch	1.5 mm
Number of clamping slots	4
Tapping hole \varnothing	20.5 mm
Number of cutting edges Z	4
Thread \varnothing	22 mm
Shank $\varnothing D_s$	18 mm
Overall length L	125 mm

Shank square <input type="checkbox"/>	14.5 mm
Tolerance class	ISO 2 6H
Tool material	HSS E PM
Standard	DIN 374
Thread depth	66 mm
Thread type	MF
Thread size	M22×1.5
Coating	TiN
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	CS
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 _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	28 m/min	N
Steel < 500 N/mm ²	suitable	27 m/min	P
Steel < 750 N/mm ²	suitable	23 m/min	P
Steel < 900 N/mm ²	suitable	17 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	7 m/min	P
Oil	suitable		

wet maximum

suitable