

Garant
Machine tap HSS-E, vaporised, MF: 22X1,5

Order data

Order number	132870 22X1,5
GTIN	4045197074096
Item class	11H

Description
Version:
Strong spiral point.

 Guide section **with oil grooves.**

Thread type: MF

Tool material: HSS E

Standard: DIN 374

Tolerance class: ISO 2X 6HX

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 cutting edges Z	3
Tapping hole \varnothing	20.5 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 2X 6HX
Tool material	HSS E
Standard	DIN 374
Thread depth	66 mm
Thread type	MF
Thread size	M22×1.5
Coating	vaporised
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 dynamic machining
Colour ring	blue
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 only under restricted conditions	15 m/min	P
INOX < 900 N/mm ²	suitable	6 m/min	M
CuZn	suitable only under restricted conditions	13 m/min	N
Oil	suitable		

wet maximum

suitable only under
restricted conditions