

**Garant**
**Machine tap HSS-E, vaporised, MF: 24X1,5**

**Order data**

Order number	132870 24X1,5
GTIN	4045197074102
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: 140 mm

 Shank  $\varnothing D_s$ : 18 mm

 Shank square  $\square$ : 14.5 mm

 Tapping hole  $\varnothing$ : 22.5 mm

**Technical description**

Tapping hole $\varnothing$	22.5 mm
Thread $\varnothing$	24 mm
Number of cutting edges Z	3
Thread pitch	1.5 mm
Number of clamping slots	3
Shank $\varnothing D_s$	18 mm
Overall length L	140 mm
Shank square $\square$	14.5 mm

Tolerance class	ISO 2X 6HX
Tool material	HSS E
Standard	DIN 374
Thread depth	72 mm
Thread type	MF
Thread size	M24×1.5
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 <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 only under restricted conditions	15 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
Oil	suitable		

wet maximum

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restricted conditions