

**Garant**
**Machine tap HSS-E-PM Form CS, TiN, MF: 24X1,5**

**Order data**

Order number	132835 24X1,5
GTIN	4045197073624
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: 140 mm

 Shank  $\varnothing D_s$ : 18 mm

 Shank square  $\square$ : 14.5 mm

 Tapping hole  $\varnothing$ : 22.5 mm

**Technical description**

Number of cutting edges Z	4
Number of clamping slots	4
Thread pitch	1.5 mm
Thread $\varnothing$	24 mm
Tapping hole $\varnothing$	22.5 mm
Shank $\varnothing D_s$	18 mm
Overall length L	140 mm

Shank square <input type="checkbox"/>	14.5 mm
Tolerance class	ISO 2 6H
Tool material	HSS E PM
Standard	DIN 374
Thread depth	72 mm
Thread type	MF
Thread size	M24×1.5
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 <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	28 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	27 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	23 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	17 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	7 m/min	P
Oil	suitable		

wet maximum

suitable