

**Garant**
**Machine tap, TiCN, MF: 22X1,5**

**Order data**

Order number	132860 22X1,5
GTIN	4045197073914
Item class	11H

**Description**
**Recommendation:**

For **TOOLOX materials** we recommend **deviating from the DIN data** (see table) by drilling the tapping hole  $\varnothing$  **0.05** to **0.3 mm** larger.

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<sub>s</sub>: 18 mm

Shank square □: 14.5 mm

Tapping hole  $\varnothing$ : 20.5 mm

**Technical description**

Number of cutting edges Z	3
Thread pitch	1.5 mm
Thread $\varnothing$	22 mm
Number of clamping slots	3
Tapping hole $\varnothing$	20.5 mm
Shank $\varnothing$ D <sub>s</sub>	18 mm
Overall length L	125 mm
Shank square □	14.5 mm

Tolerance class	ISO 2X 6HX
Tool material	HSS E
Standard	DIN 374
Thread depth	44 mm
Thread type	MF
Thread size	M22×1.5
Coating	TiCN
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	red
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	20 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	19 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	19 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	9 m/min	P
TOOLOX 33	suitable	4 m/min	H
Oil	suitable		
wet maximum	suitable		

