

Garant**Machine tap, nitrided, Tr: TR18X4****Order data**

Order number	133490 TR18X4
GTIN	4045197533074
Item class	11H

Description**Version:**

Profile correct for NC, with divided envelope cut.

Lead chamfer: ≈ 20 turns. **With 25° left-hand flutes**, right-hand cutting.

Advantage:

Suitable for reversing.

Note:

For use on synchronised spindles.

The lead must be machine driven.

Technical description

Number of cutting edges Z	3
Thread pitch	4 mm
Number of clamping slots	3
Tapping hole \varnothing	14.25 mm
Shank $\varnothing D_s$	14 mm
Overall length L	195 mm
Shank square \square	11 mm
Thread depth	21.37 mm
Thread size	18
Coating	nitrided
Thread type	TR

Flank angle	30 degrees
Tool material	HSS E
Standard	Manufacturer's standard
Tolerance class	DIN 103 7H
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 1.5xD for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Type of product	Tap

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	7 m/min	N
Steel < 500 N/mm ²	suitable	7 m/min	P
Steel < 750 N/mm ²	suitable	5 m/min	P
Steel < 900 N/mm ²	suitable	3 m/min	P
INOX < 900 N/mm ²	suitable	3 m/min	M
GG(G)	suitable	7 m/min	K
CuZn	suitable	7 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		