Garant

Trapezoidal spiral point machine tap, nitrided, Tr: TR24X5

Order data

Order number	133490 TR24X5
GTIN	4045197533098
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

Thread pitch	5 mm
Number of clamping slots	3
Tapping hole ∅	19.25 mm
Number of cutting edges Z	3
Shank ∅ D_s	18 mm
Overall length L	245 mm
Shank square ☐	14.5 mm
Thread depth	28.87 mm
Thread size	24
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 1.5×D for through holes
Cutting direction	right-hand
Type of threading tool	Maskinsnittapper til synkron bearbejdning
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/mm²	suitable	7 m/min	P
Steel < 750 N/mm²	suitable	5 m/min	P
Steel < 900 N/mm²	suitable	3 m/min	P
INOX < 900 N/mm²	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		