

Garant
Machine taps extra long HSS-E-PM Form C, vaporised, M: M20

Order data

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|--------------|---------------|
| Order number | 134670 M20 |
| GTIN | 4045197301710 |
| Item class | 11H |

Description
Version:

With extra long shank.

All sizes: Shank to DIN 376 (= shank Ø relieved).

Form C (2–3 turns lead chamfer).

Advantage:

Designed for tapping threads where access is difficult.

Thread type: M

Tool material: HSS E PM

Standard: Manufacturer's standard

Tolerance class: ISO 2 6H

Thread pitch: 2.5 mm

Overall length L: 280 mm

Shank Ø D_s: 16 mm

Shank square □: 12 mm

Tapping hole Ø: 17.5 mm

Technical description

| | |
|---------------------------|-------------------------|
| Thread pitch | 2.5 mm |
| Number of cutting edges Z | 4 |
| Number of clamping slots | 4 |
| Tapping hole Ø | 17.5 mm |
| Thread Ø | 20 mm |
| Standard | Manufacturer's standard |
| Shank Ø D _s | 16 mm |

| | |
|----------------------------------|-----------------------------------|
| Overall length L | 280 mm |
| Shank square □ | 12 mm |
| Tolerance class | ISO 2 6H |
| Tool material | HSS E PM |
| Thread depth | 60 mm |
| Thread type | M |
| Thread size | M20 |
| Coating | vaporised |
| Flank angle | 60° |
| Thread standard | DIN 13 |
| Taper lead form | C |
| Helix angle | 40° |
| Shank | Plain shank with h9 |
| Through-coolant | no |
| Application for type of drilling | up to 3×D for blind 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 | 15 m/min | N |
| Steel < 500 N/mm ² | suitable | 18 m/min | P |
| Steel < 750 N/mm ² | suitable | 18 m/min | P |
| Steel < 900 N/mm ² | suitable | 18 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 9 m/min | P |
| INOX < 900 N/mm ² | suitable | 8 m/min | M |

| | | | |
|-------------|---|----------|---|
| CuZn | suitable only under restricted conditions | 16 m/min | N |
| Uni | suitable | | |
| Oil | suitable | | |
| wet maximum | suitable only under restricted conditions | | |