

**Garant**
**Machine tap, vaporised, M: M22**

**Order data**

Order number	134851 M22
GTIN	4045197350909
Item class	11H

**Technical description**

Number of cutting edges Z	4
Thread pitch	2.5 mm
Thread Ø	22 mm
Number of clamping slots	4
Tapping hole Ø	19.5 mm
Standard	DIN 376
Shank Ø D <sub>s</sub>	18 mm
Overall length L	140 mm
Shank square □	14.5 mm
Tolerance class	ISO 2 6H
Tool material	HSS E
Thread depth	66 mm
Thread type	M
Thread size	M22
Coating	vaporised
Flank angle	60 degrees
Thread standard	DIN 13

Taper lead form	C
Helix angle	40 degrees
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 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	13 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	15 m/min	P
CuZn	suitable only under restricted conditions	13 m/min	N
Oil	suitable		
wet maximum	suitable only under restricted conditions		