

**Garant****Machine tap, vaporised, M: M20****Order data**

Order number	135150 M20
GTIN	4045197076199
Item class	11H

**Description****Version:**

**With conically offset guide thread** (3 – 4 full threads, then tapered towards the rear).

**Particularly for recessed blind hole threads** where the swarf generated remains in the tap flutes.

**Advantage:**

The tapered guide section allows the tap to be reversed with greatly reduced risk of chips jamming and causing damage to the tap.

Thread type: M

Tool material: HSS E

Standard: DIN 376

Tolerance class: ISO 2 6H

Thread pitch: 2.5 mm

Overall length L: 140 mm

Shank  $\varnothing D_s$ : 16 mm

Shank square  $\square$ : 12 mm

Tapping hole  $\varnothing$ : 17.5 mm

**Technical description**

Number of clamping slots	4
Number of cutting edges Z	4
Thread pitch	2.5 mm
Tapping hole $\varnothing$	17.5 mm
Thread $\varnothing$	20 mm

Standard	DIN 376
Shank $\varnothing D_s$	16 mm
Overall length L	140 mm
Shank square $\square$	12 mm
Tolerance class	ISO 2 6H
Tool material	HSS E
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 conventional machining
Colour ring	without
Type of product	Tap

## User data

	Suitability	$V_c$	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
GG(G)	suitable only under restricted conditions	9 m/min	K
CuZn	suitable only under restricted conditions	13 m/min	N
Oil	suitable		
wet maximum	suitable only under restricted conditions		