

Garant**Machine tap HSS-E-PM, TiN / vaporised, M: M20****Order data**

Order number	135375 M20
GTIN	4045197197986
Item class	11H

Description**Version:**

For use with **emulsion** (fat content minimum 8%).

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Recommendation:

For **TOOLOX** and **HARDOX materials** we recommend **deviating from the DIN data** (see table) by drilling the tapping hole Ø **0.05** to **0.3 mm** larger.

Technical description

Number of clamping slots	4
Thread pitch	2.5 mm
Tapping hole Ø	17.5 mm
Thread Ø	20 mm
Number of cutting edges Z	4
Standard	DIN 376
Shank Ø D _s	16 mm
Overall length L	140 mm
Shank square □	12 mm
Tolerance class	ISO 2 6H
Tool material	HSS E PM
Thread depth	60 mm

Data sheet

Thread type	M
Thread size	M20
Coating	TiN / 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 dynamic machining
Colour ring	red
Type of product	Tap

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	27 m/min	P
Steel < 750 N/mm ²	suitable	23 m/min	P
Steel < 900 N/mm ²	suitable	23 m/min	P
Steel < 1100 N/mm ²	suitable	13 m/min	P
Steel < 1400 N/mm ²	suitable	10 m/min	P
TOOLOX 33	suitable	12 m/min	H
Ti > 850 N/mm ²	suitable	5 m/min	S
Oil	suitable		
wet maximum	suitable		