

Garant
Machine tap, TiCN, M: M24

Order data

Order number	135370 M24
GTIN	4045197076779
Item class	11H

Description
Version:

With strong right-hand chip flutes, for optimum swarf evacuation.

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

Improved wear characteristics due to optimised HSS-E tool material

Recommendation:

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

Thread type: M

Tool material: HSS E

Standard: DIN 376

Tolerance class: ISO 2 6H

Thread pitch: 3 mm

Overall length L: 160 mm

Shank \varnothing D_s: 18 mm

Shank square □: 14.5 mm

Tapping hole \varnothing : 21 mm

Technical description

Number of clamping slots	4
Thread pitch	3 mm
Number of cutting edges Z	4
Tapping hole \varnothing	21 mm
Thread \varnothing	24 mm
Standard	DIN 376

Shank $\varnothing D_s$	18 mm
Overall length L	160 mm
Shank square \square	14.5 mm
Tolerance class	ISO 2 6H
Tool material	HSS E
Thread depth	48 mm
Thread type	M
Thread size	M24
Coating	TiCN
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 2×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 < 750 N/mm ²	suitable only under restricted conditions	19 m/min	P
Steel < 900 N/mm ²	suitable	19 m/min	P
Steel < 1100 N/mm ²	suitable	9 m/min	P
Steel < 1400 N/mm ²	suitable	4 m/min	P
TOOLOX 33	suitable	3 m/min	H

Oil	suitable
wet maximum	suitable