

Garant
Machine tap HSS-E-PM, TiN, M: M20

Order data

Order number	135378 M20
GTIN	4045197649515
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 \varnothing **0.05** to **0.3 mm** larger.

Thread type: M

Tool material: HSS E PM

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 □: 12 mm

Tapping hole \varnothing : 17.5 mm

Technical description

Number of cutting edges Z	3
Tapping hole \varnothing	17.5 mm
Number of clamping slots	3
Thread pitch	2.5 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 PM
Thread depth	60 mm
Thread type	M
Thread size	M20
Coating	TiN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Helix angle	25°
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 < 1100 N/mm ²	suitable	9 m/min	P
Steel < 1400 N/mm ²	suitable	7 m/min	P
TOOLOX 33	suitable	6 m/min	H
TOOLOX 44	suitable	3 m/min	H
HARDOX 500 < 1600 N/mm ²	suitable	2 m/min	H

INOX < 900 N/mm ²	suitable	9 m/min	M
INOX > 900 N/mm ²	suitable	7 m/min	M
CuZn	suitable only under restricted conditions	7 m/min	N
Oil	suitable		
wet maximum	suitable		