

**Garant**
**Machine tap HSS-E Form C, vaporised, M: M22**

**Order data**

Order number	135850 M22
GTIN	4045197077813
Item class	11H

**Description**
**Version:**
**Form C** (2–3 turns lead chamfer).

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  $\varnothing D_s$ : 18 mm

 Shank square  $\square$ : 14.5 mm

 Tapping hole  $\varnothing$ : 19.5 mm

**Technical description**

Tapping hole $\varnothing$	19.5 mm
Number of clamping slots	4
Number of cutting edges Z	4
Thread pitch	2.5 mm
Thread $\varnothing$	22 mm
Standard	DIN 376
Shank $\varnothing D_s$	18 mm
Overall length L	140 mm
Shank square $\square$	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°
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 dynamic machining
Colour ring	green
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
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	6 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	6 m/min	M
CuZn	suitable only under restricted conditions	13 m/min	N

Uni	suitable
Oil	suitable
wet maximum	suitable only under restricted conditions