

Garant
Machine tap HSS-E Form C, vaporised, M: M27

Order data

Order number	135850 M27
GTIN	4045197077837
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: 3 mm

Overall length L: 160 mm

 Shank $\varnothing D_s$: 20 mm

 Shank square \square : 16 mm

 Tapping hole \varnothing : 24 mm

Technical description

Thread \varnothing	27 mm
Tapping hole \varnothing	24 mm
Thread pitch	3 mm
Number of cutting edges Z	4
Number of clamping slots	4
Standard	DIN 376
Shank $\varnothing D_s$	20 mm
Overall length L	160 mm
Shank square \square	16 mm

Tolerance class	ISO 2 6H
Tool material	HSS E
Thread depth	81 mm
Thread type	M
Thread size	M27
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 _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	13 m/min	N
Steel < 500 N/mm ²	suitable	15 m/min	P
Steel < 750 N/mm ²	suitable	15 m/min	P
Steel < 900 N/mm ²	suitable	15 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	6 m/min	P
INOX < 900 N/mm ²	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