

Garant
Machine taps, uncoated, MF: 18X1

Order data

Order number	136250 18X1
GTIN	4045197078865
Item class	11H

Description
Version:
Sturdy design, with 15° right-hand chip flutes.

Thread type: MF

Tool material: HSS E

Standard: DIN 374

Tolerance class: ISO 2 6H

Thread pitch: 1 mm

Overall length L: 110 mm

 Shank $\varnothing D_s$: 14 mm

 Shank square \square : 11 mm

 Tapping hole \varnothing : 17 mm

Technical description

Thread pitch	1 mm
Number of clamping slots	4
Number of cutting edges Z	4
Thread \varnothing	18 mm
Tapping hole \varnothing	17 mm
Shank $\varnothing D_s$	14 mm
Overall length L	110 mm
Shank square \square	11 mm
Tolerance class	ISO 2 6H

Tool material	HSS E
Standard	DIN 374
Thread depth	36 mm
Thread type	MF
Thread size	M18×1
Coating	uncoated
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Helix angle	15°
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 conventional machining
Colour ring	without
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
Oil	suitable		
wet maximum	suitable only under restricted conditions		

