

Garant
Machine tap HSS-E, TiCN, MF: 18X1,5

Order data

Order number	136270 18X1,5
GTIN	4045197079404
Item class	11H

Description
Version:

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

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: MF

Tool material: HSS E

Standard: DIN 374

Tolerance class: ISO 2 6H

Thread pitch: 1.5 mm

Overall length L: 110 mm

Shank \varnothing D_s: 14 mm

Shank square □: 11 mm

Tapping hole \varnothing : 16.5 mm

Technical description

Thread pitch	1.5 mm
Thread \varnothing	18 mm
Number of cutting edges Z	4
Number of clamping slots	4
Tapping hole \varnothing	16.5 mm
Shank \varnothing D _s	14 mm
Overall length L	110 mm

Shank square <input type="checkbox"/>	11 mm
Tolerance class	ISO 2 6H
Tool material	HSS E
Standard	DIN 374
Thread depth	36 mm
Thread type	MF
Thread size	M18×1.5
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 < 500 N/mm ²	suitable only under restricted conditions	20 m/min	P
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
TOOLOX 33	suitable	3 m/min	H
Oil	suitable		

wet maximum

suitable