

Garant
Machine tap HSS-E-PM, vaporised, MF: 22X1,5

Order data

Order number	137055 22X1,5
GTIN	4045197585479
Item class	11H

Description
Version:

Surface vaporised for reduced edge build-up.

Thread type: MF

Tool material: HSS E PM

Standard: DIN 374

Tolerance class: ISO 2X 6HX

Thread pitch: 1.5 mm

Overall length L: 125 mm

Shank $\varnothing D_s$: 18 mm

Shank square \square : 14.5 mm

Tapping hole \varnothing : 20.5 mm

Technical description

Thread \varnothing	22 mm
Thread pitch	1.5 mm
Number of cutting edges Z	4
Number of clamping slots	4
Tapping hole \varnothing	20.5 mm
Shank $\varnothing D_s$	18 mm
Overall length L	125 mm
Shank square \square	14.5 mm
Tolerance class	ISO 2X 6HX

Tool material	HSS E PM
Standard	DIN 374
Thread depth	44 mm
Thread type	MF
Thread size	M22×1.5
Coating	vaporised
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Helix angle	20°
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	pink
Type of product	Tap

User data

	Suitability	V _c	ISO code
Steel < 900 N/mm ²	suitable only under restricted conditions	18 m/min	P
Steel < 1100 N/mm ²	suitable	9 m/min	P
Steel < 1400 N/mm ²	suitable	3 m/min	P
Ti > 850 N/mm ²	suitable	4 m/min	S
Oil	suitable		
wet maximum	suitable		