

Garant
Machine tap HSS-E, TiCN, M: M24

Order data

Order number	132450 M24
GTIN	4045197071736
Item class	11H

Description
Version:

Strong spiral point. Guide section with oil grooves, but without chip flutes.

Particularly suitable for **difficult to machine steels up to 850 N/mm²**.

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

Advantage:

Particularly strong, optimum self-guidance and no recutting when reversed.

Thread type: M

Tool material: HSS E

Standard: DIN 376

Tolerance class: ISO 2X 6HX

Thread pitch: 3 mm

Overall length L: 160 mm

Shank Ø D_s: 18 mm

Shank square □: 14.5 mm

Tapping hole Ø: 21 mm

Technical description

Number of clamping slots	3
Thread Ø	24 mm
Tapping hole Ø	21 mm
Thread pitch	3 mm
Number of cutting edges Z	3
Standard	DIN 376

Shank $\varnothing D_s$	18 mm
Overall length L	160 mm
Shank square \square	14.5 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E
Thread depth	48 mm
Thread type	M
Thread size	M24
Coating	TiCN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2×D for through 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
Aluminium (short chipping)	suitable only under restricted conditions	16 m/min	N
Steel < 500 N/mm ²	suitable	20 m/min	P
Steel < 750 N/mm ²	suitable	19 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	19 m/min	P
INOX < 900 N/mm ²	suitable	8 m/min	M
INOX > 900 N/mm ²	suitable	6 m/min	M

Ti > 850 N/mm ²	suitable	4 m/min	S
Inconel	suitable	2 m/min	S
CuZn	suitable only under restricted conditions	16 m/min	N
Oil	suitable		
wet maximum	suitable		