

**Garant****GARANT Master Tap machine tap HSS-E-PM 6HX, AlTiX, MF: 24X2****Order data**

Order number	137160 24X2
GTIN	4067263108559
Item class	111

**Description****Version:**

**GARANT Master Tap Universal taps**, designed for use in a wide spectrum of materials with high process reliability.

- **HSS-E-PM tool material for maximum wear resistance.**
- **Reduced coefficient of friction due to the new high-performance coating.**
- **Special geometry for optimum swarf evacuation.**

**Technical description**

Thread size	M24x2
Thread Ø	24 mm
Shank Ø D <sub>s</sub>	18 mm
Tolerance class	ISO 2X 6HX
Thread type	MF
Tool material	HSS E PM
Standard	DIN 374
Number of cutting edges Z	4
Thread pitch	1.5 mm
Thread depth	60 mm
Shank square □	14.5 mm
Number of clamping slots	4

## Data sheet

Tapping hole Ø	22 mm
Overall length L	140 mm
Coating	AlTiX
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2.5×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Series	Master Tap
Type of product	Tap

### User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	30 m/min	N
Aluminium (short chipping)	suitable	35 m/min	N
Alu > 10% Si	suitable	20 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	8 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	10 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	8 m/min	M

## Data sheet

GG(G)	suitable	20 m/min	K
CuZn	suitable	20 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		