

**GARANT Vap Tap machine tap HSS-E, vaporised, M: M22****Order data**

Order number	132642 M22
GTIN	4069515001809
Item class	13V

Description**Version:**

GARANT Vap Tap general-purpose tap. Can be used **reliably** in a **wide range of materials**. Optimised **neck and flute length** for **improved chip evacuation** when working on **deep** threads. High-performance **HSS-E tool material** with higher vanadium content for improved **wear resistance**. **Surface vaporised** for reduced edge build-up.

Technical description

Number of cutting edges Z	3
Overall length L	140 mm
Tolerance class	ISO 2 6H
Number of clamping slots	3
Standard	DIN 376
Thread depth	66 mm
Thread pitch	2.5 mm
Shank square □	14.5 mm
Thread type	M
Tool material	HSS E
Shank Ø D _s	18 mm
Thread Ø	22 mm

Data sheet

Tapping hole Ø	19.5 mm
Thread size	M22
Coating	vaporised
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Series	Vap Tap
Type of product	Tap

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	18 m/min	N
Aluminium (short chipping)	suitable	13 m/min	N
Steel < 500 N/mm ²	suitable	18 m/min	P
Steel < 750 N/mm ²	suitable	15 m/min	P
Steel < 900 N/mm ²	suitable	15 m/min	P
Steel < 1100 N/mm ²	suitable	6 m/min	P
INOX < 900 N/mm ²	suitable	6 m/min	M
CuZn	suitable only under restricted conditions	15 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		

