

Garant**GARANT Vap Tap machine tap HSS-E, vaporised, MF: 22X1,5****Order data**

Order number	132885 22X1,5
GTIN	4069515002134
Item class	13V

Description**Version:**

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 clamping slots	4
Tolerance class	ISO 2 6H
Standard	DIN 374
Thread depth	66 mm
Shank Ø D _s	18 mm
Overall length L	125 mm
Thread type	MF
Number of cutting edges Z	4
Tool material	HSS E
Thread pitch	1.5 mm
Tapping hole Ø	20.5 mm
Thread size	M22×1.5
Shank square □	14.5 mm

Data sheet

Thread Ø	22 mm
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
Colour ring	without
Series	Vap Tap
Type of product	Taps

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		

