

Garant**GARANT Vap Tap machine tap left-hand thread HSS-E 6H, vaporised, M-LH: M24****Order data**

Order number	136185 M24
GTIN	4069515002608
Item class	13V

Description**Version:**

GARANT Vap Tap general-purpose tap – left-hand thread. 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

Thread Ø	24 mm
Thread type	M-LH
Tool material	HSS E
Tapping hole Ø	21 mm
Shank square □	14.5 mm
Standard	DIN 376
Number of clamping slots	4
Thread depth	60 mm
Shank Ø D _s	18 mm
Overall length L	160 mm
Tolerance class	ISO 2 6H
Number of cutting edges Z	4

Data sheet

Thread pitch	3 mm
Thread size	M24
Coating	vaporised
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 3×D for blind holes
Cutting direction	left-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
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		

Data sheet

Oil	suitable
wet maximum	suitable