

**GARANT Vap Tap machine tap HSS-E Form C, vaporised, M: M27****Order data**

Order number	135805 M27
GTIN	4069515002356
Item class	13V

Description**Version:****Form C** (2–3 turns lead chamfer).**Form C** (2–3 turns lead chamfer).**Technical description**

Shank square ☐	16 mm
Tolerance class	ISO 2 6H
Thread Ø	27 mm
Shank Ø D _s	20 mm
Tool material	HSS E
Thread depth	81 mm
Number of cutting edges Z	4
Thread pitch	3 mm
Tapping hole Ø	24 mm
Thread type	M
Overall length L	160 mm
Number of clamping slots	4
Standard	DIN 376
Thread size	M27

Data sheet

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	right-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		
Oil	suitable		
wet maximum	suitable		

