

Garant
Machine tap HSS-E-PM, TiN / vaporised, MF: 18X1,5

Order data

Order number	136290 18X1,5
GTIN	4045197883599
Item class	11H

Description
Version:

With special TiN coating and vaporised cutting surfaces.

For controlled swarf evacuation and avoidance of clogging.

Especially suitable for problem materials.

For use with **emulsion** (fat content minimum 8%).

Recommendation:

For **TOOLOX materials we recommend deviating from the DIN data** (see table) by drilling the tapping hole \varnothing **0.05 to 0.3 mm** larger.

Thread type: MF

Tool material: HSS E PM

Standard: DIN 374

Tolerance class: ISO 2 6H

Thread pitch: 1.5 mm

Overall length L: 110 mm

Shank \varnothing D_s: 14 mm

Shank square □: 11 mm

Tapping hole \varnothing : 16.5 mm

Technical description

Thread \varnothing	18 mm
Thread pitch	1.5 mm
Shank \varnothing D _s	14 mm
Standard	DIN 374
Overall length L	110 mm

Number of clamping slots	4
Shank square □	11 mm
Tolerance class	ISO 2 6H
Tool material	HSS E PM
Number of cutting edges Z	4
Tapping hole Ø	16.5 mm
Thread depth	54 mm
Thread type	MF
Thread size	M18×1.5
Coating	TiN / vaporised
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 °
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	red
Type of product	Tap

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	27 m/min	P
Steel < 750 N/mm ²	suitable	23 m/min	P
Steel < 900 N/mm ²	suitable	23 m/min	P
Steel < 1100 N/mm ²	suitable	13 m/min	P
Steel < 1400 N/mm ²	suitable	10 m/min	P

TOOLOX 33	suitable	12 m/min	H
Ti > 850 N/mm ²	suitable	5 m/min	S
Oil	suitable		
wet maximum	suitable		