

**Garant**
**Machine tap HSS-E-PM, TiN / vaporised, MF: 24X1,5**

**Order data**

Order number	136290 24X1,5
GTIN	4045197883612
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: 140 mm

Shank  $\varnothing$  D<sub>s</sub>: 18 mm

Shank square □: 14.5 mm

Tapping hole  $\varnothing$ : 22.5 mm

**Technical description**

Number of clamping slots	4
Shank square □	14.5 mm
Overall length L	140 mm
Tolerance class	ISO 2 6H
Thread $\varnothing$	24 mm

Standard	DIN 374
Tapping hole $\varnothing$	22.5 mm
Shank $\varnothing D_s$	18 mm
Tool material	HSS E PM
Number of cutting edges Z	4
Thread pitch	1.5 mm
Thread depth	72 mm
Thread type	MF
Thread size	M24×1.5
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 <sup>2</sup>	suitable	27 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	23 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	23 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	13 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	10 m/min	P

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