

**Garant**
**GARANT Master Tap machine tap Form B, ALTiX, M: M20**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 132721 M20    |
| GTIN         | 4045197900463 |
| Item class   | 111           |

**Description**
**Version:**

**Universal taps**, designed for use in a wide spectrum of materials with high process reliability.

- **HSS-E-PM tool material for a high degree of wear resistance.**
- **Reduced coefficient of friction due to the new high-performance coating.**
- **Special geometry for optimum swarf evacuation.**

Corresponds to **ISO 2X/6HX**.

**Technical description**

|                           |            |
|---------------------------|------------|
| Tool material             | HSS E PM   |
| Overall length L          | 140 mm     |
| Thread pitch              | 2.5 mm     |
| Thread Ø                  | 20 mm      |
| Standard                  | DIN 376    |
| Tapping hole Ø            | 17.5 mm    |
| Tolerance class           | ISO 2X 6HX |
| Number of cutting edges Z | 4          |
| Shank Ø D <sub>s</sub>    | 16 mm      |
| Number of clamping slots  | 4          |
| Thread depth              | 60 mm      |
| Shank square □            | 12 mm      |

|                                  |                                   |
|----------------------------------|-----------------------------------|
| Thread type                      | M                                 |
| Thread size                      | M20                               |
| Coating                          | AlTiX                             |
| 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                      | green                             |
| Series                           | Master Tap                        |
| Type of product                  | Tap                               |

## User data

|                                | Suitability | V <sub>c</sub> | ISO code |
|--------------------------------|-------------|----------------|----------|
| Alu plastics                   | suitable    | 30 m/min       | N        |
| Aluminium (short chipping)     | suitable    | 35 m/min       | N        |
| Alu > 10% Si                   | suitable    | 20 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable    | 30 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 30 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 25 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 12 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable    | 8 m/min        | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable    | 10 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable    | 8 m/min        | M        |
| GG(G)                          | suitable    | 20 m/min       | K        |

|             |          |          |   |
|-------------|----------|----------|---|
| CuZn        | suitable | 20 m/min | N |
| Uni         | suitable |          |   |
| Oil         | suitable |          |   |
| wet maximum | suitable |          |   |