



## Machine tap HSS-E Form C, vaporised, M: M24



### Order data

Order number	135855 M24
GTIN	4062406088170
Item class	12H

### Description

#### Version:

**Form C** (2–3 turns lead chamfer).

Thread type: M

Tool material: HSS E

Standard: DIN 376

Tolerance class: ISO 2 6H

Thread pitch: 3 mm

Overall length L: 160 mm

Shank  $\varnothing D_s$ : 18 mm

Shank square  $\square$ : 14.5 mm

Tapping hole  $\varnothing$ : 21 mm

### Technical description

Tolerance class	ISO 2 6H
Standard	DIN 376
Tapping hole $\varnothing$	21 mm
Thread depth	72 mm
Thread pitch	3 mm
Shank square $\square$	14.5 mm
Shank $\varnothing D_s$	18 mm
Overall length L	160 mm
Number of clamping slots	4

Thread Ø	24 mm
Number of cutting edges Z	4
Thread type	M
Tool material	HSS E
Thread size	M24
Coating	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	green
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	11 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	12 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	8 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	7 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	4 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	4 m/min	M

CuZn	suitable only under restricted conditions	12 m/min	N
Uni	suitable		
Oil	suitable		