

Garant
GARANT Master Tap machine tap Form B, ALTiX, M: M18

Order data

Order number	132721 M18
GTIN	4062406266516
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**.

Thread type: M

Tool material: HSS E PM

Standard: DIN 376

Tolerance class: ISO 2X 6HX

Thread pitch: 2.5 mm

Overall length L: 125 mm

Shank \varnothing D_s: 14 mm

Shank square □: 11 mm

Tapping hole \varnothing : 15.5 mm

Technical description

Tool material	HSS E PM
Shank square □	11 mm
Overall length L	125 mm
Thread \varnothing	18 mm
Thread depth	54 mm
Thread size	ASCD18-300W2

Tolerance class	ISO 2X 6HX
Thread type	M
Number of clamping slots	4
Number of cutting edges Z	4
Tapping hole Ø	15.5 mm
Thread pitch	2.5 mm
Standard	DIN 376
Shank Ø D _s	14 mm
Coating	AlTiX
Flank angle	60°
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 _c	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 ²	suitable	30 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P

Steel < 900 N/mm ²	suitable	25 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
Steel < 1400 N/mm ²	suitable	8 m/min	P
INOX < 900 N/mm ²	suitable	10 m/min	M
INOX > 900 N/mm ²	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		