

**Garant****GARANT Vap Tap machine tap HSS-E, vaporised, M: M22****Order data**

Order number	GG1326 M22
GTIN	4069515046435
Item class	GGN

**Description****Version:**

**GARANT Vap Tap general-purpose tap.** Can be used **reliably** in a **wide range of materials**. Optimised **neck and flute length** for **improved chip evacuation** when working on **deep** threads. High-performance **HSS-E tool material** with higher vanadium content for improved **wear resistance**. **Surface vaporised** for reduced edge build-up.

**Same as number: 132642.**

**Note:**

Up to ≤ M16: contents 5 pcs. per set.

From ≥ M18: contents 3 pcs. per set.

**Technical description**

Shank Ø D <sub>s</sub>	18 mm
Thread type	M
Tolerance class	ISO 2 6H
Standard	DIN 376
Thread pitch	2.5 mm
Tapping hole Ø	19.5 mm

## Data sheet

Tool material	HSS E
Number of clamping slots	3
Shank square □	14.5 mm
Number of cutting edges Z	3
Thread Ø	22 mm
Overall length L	140 mm
Thread size	M22
Thread depth	66 mm
Contents	3"
Coating	vaporised
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
Series	Vap Tap
Type of product	Taps

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	18 m/min	N
Aluminium (short chipping)	suitable	13 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	18 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	15 m/min	P

Steel < 1100 N/mm <sup>2</sup>	suitable	6 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	6 m/min	M
CuZn	suitable only under restricted conditions	15 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		

**Suitable products**

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