ıˆ∂ **Hoffmann Group**

Garant

GARANT Master Tap INOX machine tap HSS-E-PM Form C 6GX, TiAlN, M: M12

Order data

Order number	135737 M12
GTIN	4062406209858
Item class	11I

Description

Version:

High-performance tap, specially developed for **good process reliability in stainless and acid-resistant steels** and **duplex materials.**

The 45° helix angle of the flutes facilitates chip formation especially in ductile austenitic CrNi steels.

· **HSS-E-PM tool material for a high degree of wear resistance**
· **The latest generation of TiALN multi-layer coating**
· **Parameterised flute geometry for optimum chip formation and torsional rigidity**

Tolerance class ISO 3X/6GX. For components which are **galvanised** or shrink slightly when hardened.

Thread type: M
Tool material: HSS E PM
Standard: DIN 376
Tolerance class: ISO 3X 6GX
Thread pitch: 1.75 mm
Overall length L: 110 mm
Shank Ø D_s: 9 mm
Shank square □: 7 mm
Tapping hole Ø: 10.2 mm

Technical description

Shank square □	7 mm
Tool material	HSS E PM
Overall length L	110 mm

Thread type	M
Tapping hole Ø	10.2 mm
Thread depth	30 mm
Number of cutting edges Z	4
Standard	DIN 376
Tolerance class	ISO 3X 6GX
Thread pitch	1.75 mm
Shank Ø D_s	9 mm
Number of clamping slots	4
Thread size	M12
Thread Ø	12 mm
Coating	TiAlN
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	C
Helix angle	45 °
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2.5×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	blue
Series	Master Tap
Type of product	Tap

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	28 m/min	N

Steel < 750 N/mm²	suitable only under restricted conditions	23 m/min	P
Steel < 900 N/mm²	suitable only under restricted conditions	23 m/min	P
Steel < 1100 N/mm²	suitable	12 m/min	P
INOX < 900 N/mm²	suitable	11 m/min	M
INOX > 900 N/mm²	suitable	9 m/min	M
Oil	suitable		
wet maximum	suitable		