

Garant

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



Order data

Order number	135739 M12
GTIN	4062406209957
Item class	111

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**

With extra long shank. Shank to DIN 376.

Advantage:

Designed for tapping threads where access is difficult.

Technical description

Thread pitch	1.75 mm
Thread depth	30 mm
Shank $\varnothing D_s$	9 mm
Thread \varnothing	12 mm
Tool material	HSS E PM
Overall length L	220 mm
Standard	Manufacturer's standard
Shank square \square	7 mm

Number of clamping slots	4
Thread size	M12
Thread type	M
Tolerance class	ISO 2X 6HX
Tapping hole Ø	10.2 mm
Number of cutting edges Z	4
Coating	TiAlN
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	C
Helix angle	45 degrees
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	20 m/min	N
Steel < 750 N/mm ²	suitable only under restricted conditions	16 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	16 m/min	P
Steel < 1100 N/mm ²	suitable	8 m/min	P
INOX < 900 N/mm ²	suitable	7 m/min	M

INOX > 900 N/mm ²	suitable	6 m/min	M
Oil	suitable		
wet maximum	suitable		