

Garant
GARANT Master Tap SteelHT machine tap HSS-E-PM Form B 6HX, TiCN, M: M12

Order data

Order number	131940 M12
GTIN	4062406236205
Item class	11I

Description
Version:

High-performance tap, specially developed for use in **steels with high tensile strength** and for **difficult-to-machine materials**. **Strong spiral point**, for process stability at high cutting forces.

- **HSS-E-PM tool material – for very high cutting edge stability.**
- **Optimised honed cutting edges.**
- **TiCN coating – for maximum wear protection.**

Recommendation:

For **TOOLOX** and **HARDOX** materials we recommend deviating from the **DIN data** (see table) by **selecting a larger tapping hole \varnothing** .

Technical description

Thread size	M12
Shank square \square	7 mm
Number of clamping slots	3
Thread \varnothing	12 mm
Number of cutting edges Z	3
Tapping hole \varnothing	10.2 mm
Thread type	M
Thread depth	36 mm
Overall length L	110 mm

Tool material	HSS E PM
Tolerance class	ISO 2X 6HX
Shank $\varnothing D_s$	9 mm
Standard	DIN 376
Thread pitch	1.75 mm
Coating	TiCN
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
Colour ring	red
Series	Master Tap
Type of product	Tap

User data

	Suitability	V_c	ISO code
Steel < 750 N/mm ²	suitable only under restricted conditions	30 m/min	P
Steel < 900 N/mm ²	suitable	20 m/min	P
Steel < 1100 N/mm ²	suitable	15 m/min	P
Steel < 1400 N/mm ²	suitable		
Steel < 50 HRC	suitable only under restricted conditions		
TOOLOX 33	suitable	15 m/min	H
TOOLOX 44	suitable		

INOX > 900 N/mm ²	suitable
Ti > 850 N/mm ²	suitable only under restricted conditions
Oil	suitable
wet maximum	suitable