

**Garant**
**GARANT Master Tap SteelHT machine tap HSS-E-PM Form B 6HX, TiCN, MF: 12X1**

**Order data**

Order number	132855 12X1
GTIN	4062406236595
Item class	11l

**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  $\varnothing$ .**

Thread type: MF

Tool material: HSS E PM

Standard: DIN 374

Tolerance class: ISO 2X 6HX

Thread pitch: 1 mm

Overall length L: 100 mm

Shank  $\varnothing$  D<sub>s</sub>: 9 mm

Shank square □: 7 mm

Tapping hole  $\varnothing$ : 11 mm

**Technical description**

Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Tapping hole $\varnothing$	11 mm

Thread type	MF
Thread pitch	1 mm
Standard	DIN 374
Overall length L	100 mm
Thread depth	36 mm
Thread Ø	12 mm
Number of clamping slots	3
Shank square □	7 mm
Number of cutting edges Z	3
Shank Ø D <sub>s</sub>	9 mm
Coating	TiCN
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
Series	Master Tap
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 750 N/mm <sup>2</sup>	Suitable only under restricted conditions	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	12 m/min	P

Steel < 50 HRC	Suitable only under restricted conditions		
TOOLOX 33	suitable	15 m/min	H
TOOLOX 44	suitable		
HARDOX 500 < 1600 N/mm <sup>2</sup>	suitable only under restricted conditions		
INOX > 900 N/mm <sup>2</sup>	suitable		
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		