

Garant
Synchronised fluteless machine tap with oil grooves Solid carbide IC, TiAlN, M: M12

Order data

Order number	139243 M12
GTIN	4045197365682
Item class	11H

Description
Version:

Special polygon geometry and shank to DIN 6535-HA for use on machines with **synchronised spindle drives. With oil grooves; optimal lubrication effect even in deeper threads.**

Special solid carbide tool material for high cutting speeds and long tool life. **TiAlN and anti-friction coating** ensure low wear and low tendency to edge build-up.

With internal coolant supply laterally from the grooves; recommended for through and blind holes.

Note:

For use on synchronised spindles, the GARANT quick-change tapping chuck No. 338100 – 338121 with minimum length adjustment (MLA) ensures very high process reliability.

Tolerance class: ISO 2X 6HX

Thread pitch: 1.75 mm

Overall length L: 110 mm

Shank $\varnothing D_s$: 12 mm

Shank square \square : 9 mm

Tapping hole \varnothing guide value: 11.2 mm

Technical description

Number of clamping slots	6
Thread \varnothing	12 mm
Number of cutting edges Z	6
Thread pitch	1.75 mm

Shank $\varnothing D_s$	12 mm
Shank square \square	9 mm
Overall length L	110 mm
Tapping hole \varnothing guide value	11.2 mm
Tolerance class	ISO 2X 6HX
Thread depth	36 mm
Thread size	M12
Coating	TiAlN
Thread type	M
Flank angle	60°
Tool material	Solid carbide
Standard	Manufacturer's standard
Thread standard	DIN 13
Taper lead form	C
Shank	DIN 6535 HA with h6
Through-coolant	yes
Application for type of drilling	up to 3xD for blind holes
Application for type of drilling	up to 3xD for through holes
Cutting direction	right-hand
Shank tolerance	h6
Colour ring	without
Type of product	Fluteless tap

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	53 m/min	N
Aluminium (short chipping)	suitable	53 m/min	N

Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm ²	suitable	55 m/min	P
Steel < 750 N/mm ²	suitable	50 m/min	P
Steel < 900 N/mm ²	suitable	47 m/min	P
Steel < 1100 N/mm ²	suitable	43 m/min	P
Steel < 1400 N/mm ²	suitable	36 m/min	P
Oil	suitable		
wet maximum	suitable		