Garant

Synchronised fluteless machine tap with oil grooves HSS-E-PM IC / Form C, TiN, M: M12

Order data

Order number	139230 M12
GTIN	4045197446992
Item class	11H

Description

Version:
Special polygon geometry and shank to DIN 1835-B for machines with **synchronised spindle drive. With oil grooves; optimal lubrication effect even in deeper threads.**
The **innovative polygon form** permits a wide application spectrum. The **multi-function layered coating** achieves **maximum service life** even in **high-tensile materials** in **fixed** applications.
With internal coolant supply laterally from the grooves; permits maximum tool life.
Note:
For use on synchronised spindles, the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures the highest process reliability.
Tolerance class: ISO 2X 6HX
Thread pitch: 1.75 mm
Overall length L: 110 mm
Shank ⌀ D_s: 12 mm
Shank square ☐: 9 mm
Tapping hole ⌀ guide value: 11.2 mm

Technical description

Thread pitch	1.75 mm
Number of cutting edges Z	5
Thread ⌀	12 mm
Number of clamping slots	5
Shank ⌀ D_s	12 mm

Shank square ☐	9 mm
Overall length L	110 mm
Tapping hole ∅ guide value	11.2 mm
Tolerance class	ISO 2X 6HX
Thread depth	30 mm
Thread size	M12
Coating	TiN
Thread type	M
Flank angle	60 °
Tool material	HSS E PM
Standard	Manufacturer's standard
Thread standard	DIN 13
Taper lead form	C
Shank	DIN 1835 B with h6
Through-coolant	yes
Application for type of drilling	up to 2×D for blind holes
Application for type of drilling	up to 2.5×D for through holes
Cutting direction	right-hand
Shank tolerance	h6
Colour ring	green
Type of product	Fluteless tap

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	48 m/min	N
Aluminium (short chipping)	suitable	48 m/min	N
Alu > 10% Si	suitable only under restricted conditions	45 m/min	N

Steel < 500 N/mm²	suitable	50 m/min	P
Steel < 750 N/mm²	suitable	42 m/min	P
Steel < 900 N/mm²	suitable	40 m/min	P
Steel < 1100 N/mm²	suitable	37 m/min	P
Steel < 1400 N/mm²	suitable only under restricted conditions	27 m/min	P
INOX < 900 N/mm²	suitable	10 m/min	M
CuZn	suitable only under restricted conditions	40 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		