Garant

Solid carbide machine tap, TiAlN, MF: 12X1,5

Order data

Order number	132862 12X1,5
GTIN	4045197073969
Item class	11H

Description

Version:
Particularly sturdy version. For the highest performance demands.
Recommendation:
For **very hard steels, TOOLOX** and **HARDOX materials** we recommend **deviating from the DIN data** (see table) by drilling the tapping hole ∅ **0.05** to **0.3mm** larger.
For use only with a length compensation chuck – even on machines with synchronised spindle drives.

Technical description

Thread ∅	12 mm
Number of clamping slots	5
Tapping hole ∅	10.5 mm
Thread pitch	1.5 mm
Number of cutting edges Z	5
Shank ∅ D_s	12 mm
Overall length L	110 mm
Shank square ☐	9 mm
Tolerance class	ISO 2X 6HX
Tool material	Solid carbide
Standard	DIN 371
Thread depth	18 mm

Thread type	MF
Thread size	M12×1.5
Coating	TiAlN
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	D
Shank	Parallel shank to h6
Through-coolant	no
Application for type of drilling	up to 1.5×D for blind holes
Application for type of drilling	up to 2×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	red
Type of product	Tap

User data

	Suitability	V_c	ISO code
Steel < 55 HRC	suitable	3 m/min	H
Steel < 60 HRC	suitable	2 m/min	H
Steel < 65 HRC	suitable only under restricted conditions	1 m/min	H
Steel < 67 HRC	suitable only under restricted conditions	1 m/min	H
TOOLOX 33	suitable only under restricted conditions	5 m/min	H
TOOLOX 44	suitable only under restricted conditions	4 m/min	H
HARDOX 500 < 1600 N/mm^2	suitable only under restricted conditions	3 m/min	H
Graphite, GRP, CRP	suitable only under restricted conditions	18 m/min	N

Oil	suitable