

**Garant**
**Machine tap, uncoated, UNF: 1-12**

**Order data**

Order number	133400 1-12
GTIN	4045197074843
Item class	11H

**Description**
**Version:**
**With spiral point.**
**Application:**
**For UNF uniform fine threads ASME – B1.1.**

Thread type: UNF

Tool material: HSS

Standard: DIN 374

Threads per inch: 12

Thread Ø: 25.4 mm

Overall length L: 140 mm

 Shank Ø D<sub>s</sub>: 20 mm

Shank square □: 16 mm

Tapping hole Ø: 23.25 mm

**Technical description**

Number of clamping slots	3
Tapping hole Ø	23.25 mm
Number of cutting edges Z	3
Threads per inch	12
Thread Ø	25.4 mm
Standard	DIN 374
Tool material	HSS

Shank $\varnothing D_s$	20 mm
Overall length L	140 mm
Shank square $\square$	16 mm
Thread depth	76.2 mm
Thread pitch	2.117 mm
Thread type	UNF
Thread size	1-12 UNF
Coating	uncoated
Flank angle	60 °
Tolerance class	2B
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 conventional machining
Colour ring	without
Type of product	Tap

## User data

	Suitability	$V_c$	ISO code
Aluminium	suitable only under restricted conditions	13 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	13 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	15 m/min	P
Oil	suitable		

wet maximum

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restricted conditions