

**Machine tap, uncoated, UNF: 1-12****Order data**

Order number	133402 1-12
GTIN	4045197594853
Item class	12H

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

Thread Ø	25.4 mm
Tapping hole Ø	23.25 mm
Number of cutting edges Z	4
Threads per inch	12
Number of clamping slots	4
Standard	DIN 374
Tool material	HSS E
Shank Ø D _s	18 mm
Overall length L	140 mm
Shank square □	14.5 mm
Thread depth	76.2 mm
Thread pitch	2.117 mm
Thread type	UNF

Data sheet

Thread size	1-12 UNF
Coating	uncoated
Flank angle	60 degrees
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 (short chipping)	suitable only under restricted conditions	13 m/min	N
Steel < 500 N/mm ²	suitable	15 m/min	P
Steel < 750 N/mm ²	suitable	15 m/min	P
Oil	suitable		
wet maximum	suitable only under restricted conditions		