

**Garant**
**Machine tap for synchronised spindles HSS-E-PM Form C, DLC, M: M12**

**Order data**

Order number	134275 M12
GTIN	4045197649188
Item class	11H

**Description**
**Version:**

**Sturdy version with right-hand helix and shank to DIN 1835-B.** Special geometry for use on machines with **synchronised spindle drives**. The tap is controlled by the synchronising spindle of the machine. With the latest generation of special **DLC coating sp<sup>2</sup>** for optimum tool life. For use with **emulsion** (fat content minimum 8%).

**Note:**

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

Thread type: M

Tool material: HSS E PM

Standard: Manufacturer's standard

Tolerance class: ISO 2X 6HX

Thread pitch: 1.75 mm

Overall length L: 110 mm

Shank Ø D<sub>s</sub>: 12 mm

Shank square □: 9 mm

Tapping hole Ø: 10.2 mm

**Technical description**

Number of cutting edges Z	3
Tapping hole Ø	10.2 mm
Number of clamping slots	3
Thread pitch	1.75 mm
Thread Ø	12 mm

Standard	Manufacturer's standard
Shank $\varnothing D_s$	12 mm
Overall length L	110 mm
Shank square $\square$	9 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Thread depth	30 mm
Thread type	M
Thread size	M12
Coating	DLC
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Helix angle	40°
Shank	DIN 1835 B to h6
Through-coolant	no
Application for type of drilling	up to 2.5×D for blind holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	yellow
Type of product	Tap

## User data

	Suitability	$V_c$	ISO code
Aluminium	suitable	30 m/min	N
Aluminium (short chipping)	suitable	35 m/min	N
Alu > 10% Si	suitable	20 m/min	N

PMMA acrylic	suitable	25 m/min	N
PA 66 GF30	suitable only under restricted conditions	20 m/min	N
PTFE CF25	suitable	25 m/min	N
Cu	suitable	55 m/min	N
CuZn	suitable	35 m/min	N
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		