

**Garant**
**Machine tap, TiN, M: M12**

**Order data**

Order number	135100 M12
GTIN	4045197076069
Item class	11H

**Description**
**Version:**

Applicable with higher cutting speeds and **emulsion** (fat content minimum 8 %) due to improved wear resistance.

**Technical description**

Tapping hole $\varnothing$	10.2 mm
Thread pitch	1.75 mm
Number of cutting edges Z	3
Thread $\varnothing$	12 mm
Number of clamping slots	3
Standard	DIN 376
Shank $\varnothing D_s$	9 mm
Overall length L	110 mm
Shank square $\square$	7 mm
Tolerance class	ISO 2 6H
Tool material	HSS E
Thread depth	36 mm
Thread type	M
Thread size	M12

Coating	TiN
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3xD for blind 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 <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	16 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	19 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	19 m/min	P
GG(G)	suitable only under restricted conditions	14 m/min	K
CuZn	suitable only under restricted conditions	16 m/min	N
Oil	suitable		
wet maximum	suitable		